Work Order ID 123262 *123262*

August-06-14 9:02:06 AM

Item ID: D350-636-012 **Accept** *N900040100* **Setup Start** *NS1*

Revision ID: **Stop** *NS2*

Item Name: Skidtube RH Aerazur / Apical Cylindrical Compat.

Start Date: 8/07/14 **Start Qty:** 1.00 *1* **Cust Item ID:**

Required Date: 8/14/14 **Req'd Qty:** 1.00 *1* **Customer:**

Reference:

Run Start *NR1*

Approvals: **Process Plan:** WM **Date:** 08/06/14 **Tooling:** _____ **Date:** _____

Stop *NR2*

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
100	Document Control	0.00							
100	DOCUMENT CONTROL								
DC	**Memo**	0.00							
Doc.Control -USB or Paperwork									

Draw Nbr	Revision Nbr
D2750-042	G
D3492	C

SEP 04 2014

record fwd angle: 89° Dx

SEP 04 2014

DAS 06 9-89

Photocopy blue file and type labels per PPP D350-636-012 CHG 007

B123262RH

DART AEROSPACE

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date:

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	**DISPOSITION** Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	**AGAINST DEPARTMENT/PROCESS** Skid-tube ☐ Crosstube ☐ Water Jet ☐ Engineering ☐ Machining ☐ Small Fab ☐ Prod. Eng. Coor. ☐ Quality ☐ Thermoforming ☐ Finishing ☐ Rec/Store/Packaging ☐ Other ☐ Large Fab ☐ Composite ☐ Supplier ☐

Root Cause		Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design	☐									
Doc/Data	☐									
Equip/Tooling	☐									
Handling/Pre	☐									
Material	☐									
Operator	☐									
Offset/Setup	☐									
Process	☐									
Supplier	☐									
Training	☐									
Transport	☐									
Unapproved	☐									

FAULT CATEGORY

Landing Gear

- ☐ Bending
- ☐ Centre Not Concentric
- ☐ Cracks
- ☐ Crimp/Kink/Ripple/Wave
- ☐ Cuffs
- ☐ Crushing
- ☐ Heat Treat
- ☐ Inspection Strip in Tube
- ☐ Marks/Chatter
- ☐ Turning Sequence
- ☐ Wave/Twist in Tube

General

- ☐ Bend
- ☐ BOM/Route
- ☐ Broken/Damage/Defect
- ☐ Burrs
- ☐ Contamination
- ☐ Countersink
- ☐ Cut Too Short
- ☐ Drawing
- ☐ Drill Holes
- ☐ Finish
- ☐ Fit/Function
- ☐ Folio/Program
- ☐ Grain
- ☐ Hardware
- ☐ Inspection Incomplete/Unqualified
- ☐ Instructions Incomplete/Unclear
- ☐ Misaligned/off center
- ☐ Mislabeled
- ☐ Misread
- ☐ Off-set
- ☐ Out of Calibration
- ☐ Out of Sequence
- ☐ Outside Dimensions
- ☐ Over/Under tolerance
- ☐ Part Incorrect
- ☐ Part Lost/Missing
- ☐ Part Moved
- ☐ Positioned Wrong
- ☐ Power Loss/Surge
- ☐ Pressure/Forced
- ☐ Set-up
- ☐ Temperature/Cure
- ☐ Weld
- ☐ Wrong Stock Pulled
- ☐ Other

_____

_____

_____

Work Order ID 123262

August-06-14 9:02:06 AM

123262

Item ID: D350-636-012 **Accept** *N900040100* **Setup Start** *NS1*

Revision ID:

Item Name: Skidtube RH Aerazur / Apical Cylindrical Compat. **Stop** *NS2*

Start Date: 8/07/14 **Start Qty:** 1.00 *1* **Cust Item ID:**

Required Date: 8/14/14 **Req'd Qty:** 1.00 *1* **Customer:**

Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____ **Run Start** *NR1*

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____ **Stop** *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
110		0.00							
110	Skidtubes								
Skidtubes		0.00							
Skidtubes									

Memo

1- Pick D2600-3 Bent

2- Deburr FWD and AFT ends, remove bending marks. Scribe batch# inside AFT end per dwg D2750

3- Drill pilot holes for blade fitting bolt holes using DT8983. Start with 3/16", then open to 0.500" using center drill then ream holes using 0.500" reamer. PIN first side. Repeat process on second side.

ENSURE PROPER POSITIONING FWD BEND MUST BE FACING UP WHEN DRILLING FIRST SIDE

5- Drill pilot holes as per Dwg D2750 sheet 4 (D2750-2 details).Drill using drill Jig DT8150 & DT8863A for second side only DT8863B for first side (detail K)

4- Locate DT8329 off of blade fitting bolt holes and drill pilot holes for blade fitting. Open to 0.500" using hole saw. VERIFY AND RECORD FWD BEND ANGLE.

5- Drill only two fwd step holes using DT9616. Ensure proper positioning.

6- Drill pilot holes for wearplates as per Dwg D2750 using DT8108 open to 0.297".

7- Open up holes of Detail J to 0.297" (total of 2 holes per side)

8- Weld D2744 Cap as per Dwg D2750 and QSI 004.Fill grooves in bend left from bending as per QSI 004

DGC 14-8-14

BE 14-08-14

DART AEROSPACE

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date:

Work Order update only ☐

	DISPOSITION	AGAINST DEPARTMENT/PROCESS			
Work Order: _____	Rework ☐	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐
Part No. _____	Scrap ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coor. ☐	Quality ☐
	Use-as-is ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐
NCR No. _____	Suspected Unapproved ☐	Large Fab ☐	Composite ☐	Supplier ☐	

Root Cause		Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design	☐									
Doc/Data	☐									
Equip/Tooling	☐									
Handling/Pre	☐									
Material	☐									
Operator	☐									
Offset/Setup	☐									
Process	☐									
Supplier	☐									
Training	☐									
Transport	☐									
Unapproved	☐									

FAULT CATEGORY

Landing Gear	General			
☐ Bending	☐ Bend	☐ Folio/Program	☐ Outside Dimensions	☐ Pressure/Forced
☐ Centre Not Concentric	☐ BOM/Route	☐ Grain	☐ Over/Under tolerance	☐ Set-up
☐ Cracks	☐ Broken/Damage/Defect	☐ Hardware	☐ Part Incorrect	☐ Temperature/Cure
☐ Crimp/Kink/Ripple/Wave	☐ Burrs	☐ Inspection Incomplete/Unqualified	☐ Part Lost/Missing	☐ Weld
☐ Cuffs	☐ Contamination	☐ Instructions Incomplete/Unclear	☐ Part Moved	☐ Wrong Stock Pulled
☐ Crushing	☐ Countersink	☐ Misaligned/off center	☐ Positioned Wrong	
☐ Heat Treat	☐ Cut Too Short	☐ Mislabeled	☐ Power Loss/Surge	☐ Other
☐ Inspection Strip in Tube	☐ Drawing	☐ Misread		
☐ Marks/Chatter	☐ Drill Holes	☐ Off-set		
☐ Turning Sequence	☐ Finish	☐ Out of Calibration		
☐ Wave/Twist in Tube	☐ Fit/Function	☐ Out of Sequence		

Work Order ID 123262

August-06-14 9:02:06 AM

123262

Item ID: D350-636-012 **Accept** *N9000040100* **Setup Start** *NS1*

Revision ID:

Item Name: Skidtube RH Aerazur / Apical Cylindrical Compat. **Stop** *NS2*

Start Date: 8/07/14 **Start Qty:** 1.00 *1* **Cust Item ID:**

Required Date: 8/14/14 **Req'd Qty:** 1.00 *1* **Customer:**

Reference:

Run Start *NR1*

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Stop *NR2*

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
	A/R Aluminum Rod batch: M129285 > BE140814								
	9- Grind welds flush as per Dwg D2750								
120	QC10- Inspect visual per QSI004- ground welds	0.00							
120 QC Quality Control	**Memo**	0.00				0	14-08-13		DAS 9 89
130	QC5- Inspect part completeness to step on W/O	0.00							DAS 9 89
130 QC Quality Control	**Memo**	0.00				0	14-08-18		

DART AEROSPACE

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date:

Work Order update only ☐

Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION

- Rework ☐
- Scrap ☐
- Use-as-is ☐
- Suspected Unapproved ☐

AGAINST DEPARTMENT/PROCESS

- Skid-tube ☐
- Machining ☐
- Thermoforming ☐
- Large Fab ☐
- Crosstube ☐
- Small Fab ☐
- Finishing ☐
- Composite ☐
- Water Jet ☐
- Prod. Eng. Coor. ☐
- Rec/Store/Packaging ☐
- Supplier ☐
- Engineering ☐
- Quality ☐
- Other ☐

Root Cause		Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design	☐									
Doc/Data	☐									
Equip/Tooling	☐									
Handling/Pre	☐									
Material	☐									
Operator	☐									
Offset/Setup	☐									
Process	☐									
Supplier	☐									
Training	☐									
Transport	☐									
Unapproved	☐									

FAULT CATEGORY

Landing Gear

- ☐ Bending
- ☐ Centre Not Concentric
- ☐ Cracks
- ☐ Crimp/Kink/Ripple/Wave
- ☐ Cuffs
- ☐ Crushing
- ☐ Heat Treat
- ☐ Inspection Strip in Tube
- ☐ Marks/Chatter
- ☐ Turning Sequence
- ☐ Wave/Twist in Tube

General

- ☐ Bend
- ☐ BOM/Route
- ☐ Broken/Damage/Defect
- ☐ Burrs
- ☐ Contamination
- ☐ Countersink
- ☐ Cut Too Short
- ☐ Drawing
- ☐ Drill Holes
- ☐ Finish
- ☐ Fit/Function
- ☐ Folio/Program
- ☐ Grain
- ☐ Hardware
- ☐ Inspection Incomplete/Unqualified
- ☐ Instructions Incomplete/Unclear
- ☐ Misaligned/off center
- ☐ Mislabeled
- ☐ Misread
- ☐ Off-set
- ☐ Out of Calibration
- ☐ Out of Sequence
- ☐ Outside Dimensions
- ☐ Over/Under tolerance
- ☐ Part Incorrect
- ☐ Part Lost/Missing
- ☐ Part Moved
- ☐ Positioned Wrong
- ☐ Power Loss/Surge
- ☐ Pressure/Forced
- ☐ Set-up
- ☐ Temperature/Cure
- ☐ Weld
- ☐ Wrong Stock Pulled
- ☐ Other

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_____

Work Order ID 123262

August-06-14 9:02:06 AM

123262

Item ID: D350-636-012 **Accept** *N900040100* **Setup Start** *NS1*

Revision ID:

Item Name: Skidtube RH Aerazur / Apical Cylindrical Compat. **Stop** *NS2*

Start Date: 8/07/14 **Start Qty:** 1.00 *1* **Cust Item ID:**

Required Date: 8/14/14 **Req'd Qty:** 1.00 *1* **Customer:**

Reference:

Run Start *NR1*

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Stop *NR2*

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140	Chemical Conversion Coat per QSI005 4.1	0.00							
140 HandFinish	Memo	0.00				14-8-18			
Hand Finishing									
150	QC7-Inspect Chemical Conversion Coat	0.00							
150 QC	Memo	0.00				DAS 03 8-89	14-8-18		
Quality Control									

DART AEROSPACE

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date:

Work Order update only ☐

Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION

- Rework ☐
- Scrap ☐
- Use-as-is ☐
- Suspected Unapproved ☐

AGAINST DEPARTMENT/PROCESS

- Skid-tube ☐
- Machining ☐
- Thermoforming ☐
- Large Fab ☐
- Crosstube ☐
- Small Fab ☐
- Finishing ☐
- Composite ☐
- Water Jet ☐
- Prod. Eng. Coor. ☐
- Rec/Store/Packaging ☐
- Supplier ☐
- Engineering ☐
- Quality ☐
- Other ☐

Root Cause		Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design	☐									
Doc/Data	☐									
Equip/Tooling	☐									
Handling/Pre	☐									
Material	☐									
Operator	☐									
Offset/Setup	☐									
Process	☐									
Supplier	☐									
Training	☐									
Transport	☐									
Unapproved	☐									

FAULT CATEGORY

Landing Gear

- ☐ Bending
- ☐ Centre Not Concentric
- ☐ Cracks
- ☐ Crimp/Kink/Ripple/Wave
- ☐ Cuffs
- ☐ Crushing
- ☐ Heat Treat
- ☐ Inspection Strip in Tube
- ☐ Marks/Chatter
- ☐ Turning Sequence
- ☐ Wave/Twist in Tube

General

- ☐ Bend
- ☐ BOM/Route
- ☐ Broken/Damage/Defect
- ☐ Burrs
- ☐ Contamination
- ☐ Countersink
- ☐ Cut Too Short
- ☐ Drawing
- ☐ Drill Holes
- ☐ Finish
- ☐ Fit/Function
- ☐ Folio/Program
- ☐ Grain
- ☐ Hardware
- ☐ Inspection Incomplete/Unqualified
- ☐ Instructions Incomplete/Unclear
- ☐ Misaligned/off center
- ☐ Mislabeled
- ☐ Misread
- ☐ Off-set
- ☐ Out of Calibration
- ☐ Out of Sequence
- ☐ Outside Dimensions
- ☐ Over/Under tolerance
- ☐ Part Incorrect
- ☐ Part Lost/Missing
- ☐ Part Moved
- ☐ Positioned Wrong
- ☐ Power Loss/Surge
- ☐ Pressure/Forced
- ☐ Set-up
- ☐ Temperature/Cure
- ☐ Weld
- ☐ Wrong Stock Pulled
- ☐ Other

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Work Order ID 123262

August-06-14 9:02:06 AM

123262

Item ID: D350-636-012

Revision ID:

Item Name: Skidtube RH Aerazur / Apical Cylindrical Compat.

Accept *N9000400100*

Setup Start *NS1*

Stop *NS2*

Start Date: 8/07/14 **Start Qty:** 1.00 *1*

Required Date: 8/14/14 **Req'd Qty:** 1.00 *1*

Reference:

Cust Item ID:

Customer:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Run Start *NR1*

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160		0.00							
160	Skidtubes								
Skidtubes		0.00							
Skidtubes									

Memo

1- Open up holes of Detail L using hole saw and ground handling to 0.625" (total of 8 holes per side) as per dwg D2750.

2- Open up holes of Detail K using hole saw to 0.750" (total of 4 holes per side) as per dwg D2750.

3- Open float holes using uni-bit to .500" (4 per Side)

4- Chamfer holes of Detail K, L, ground handling and float holes per dwg D2750 (welding instructions on sheet 9)

5- Deburr and blow out all chips from inside of tube

6- Prepare tube for welding, remove alodine as required.

7- Bond web D2739 in place as per QSI 015, let cure for 12hrs.
A/R Sikaflex-291 batch: 129457
exp. date: 14-11-20

14-8-18

8- Weld spacers D3490-1, D3490-3 and D2743 as per dwg D2750 & QSI004 (welding instructions on sheet 9)
A/R Aluminum Rod batch: M129285

8E4-089

9- At section AP-AP drill out x-bolt spacer to 0.404"

10-Grind welds flush as per Dwg D2750

14-8-20

11- Spot face ground handling holes section (total of 4 places per side) as per

DART AEROSPACE

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date:

Work Order update only ☐

Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION

- Rework ☐
- Scrap ☐
- Use-as-is ☐
- Suspected Unapproved ☐

AGAINST DEPARTMENT/PROCESS

- Skid-tube ☐
- Machining ☐
- Thermoforming ☐
- Large Fab ☐
- Crosstube ☐
- Small Fab ☐
- Finishing ☐
- Composite ☐
- Water Jet ☐
- Prod. Eng. Coor. ☐
- Rec/Store/Packaging ☐
- Supplier ☐
- Engineering ☐
- Quality ☐
- Other ☐

Root Cause		Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design	☐									
Doc/Data	☐									
Equip/Tooling	☐									
Handling/Pre	☐									
Material	☐									
Operator	☐									
Offset/Setup	☐									
Process	☐									
Supplier	☐									
Training	☐									
Transport	☐									
Unapproved	☐									

FAULT CATEGORY

Landing Gear

- ☐ Bending
- ☐ Centre Not Concentric
- ☐ Cracks
- ☐ Crimp/Kink/Ripple/Wave
- ☐ Cuffs
- ☐ Crushing
- ☐ Heat Treat
- ☐ Inspection Strip in Tube
- ☐ Marks/Chatter
- ☐ Turning Sequence
- ☐ Wave/Twist in Tube

General

- ☐ Bend
- ☐ BOM/Route
- ☐ Broken/Damage/Defect
- ☐ Burrs
- ☐ Contamination
- ☐ Countersink
- ☐ Cut Too Short
- ☐ Drawing
- ☐ Drill Holes
- ☐ Finish
- ☐ Fit/Function
- ☐ Folio/Program
- ☐ Grain
- ☐ Hardware
- ☐ Inspection Incomplete/Unqualified
- ☐ Instructions Incomplete/Unclear
- ☐ Misaligned/off center
- ☐ Mislabeled
- ☐ Misread
- ☐ Off-set
- ☐ Out of Calibration
- ☐ Out of Sequence
- ☐ Outside Dimensions
- ☐ Over/Under tolerance
- ☐ Part Incorrect
- ☐ Part Lost/Missing
- ☐ Part Moved
- ☐ Positioned Wrong
- ☐ Power Loss/Surge
- ☐ Pressure/Forced
- ☐ Set-up
- ☐ Temperature/Cure
- ☐ Weld
- ☐ Wrong Stock Pulled
- ☐ Other

_____

_____

_____

Work Order ID 123262

August-06-14 9:02:06 AM

123262

Item ID: D350-636-012 **Accept** *N9000040100* **Setup Start** *NS1*

Revision ID:

Item Name: Skidtube RH Aerazur / Apical Cylindrical Compat. **Stop** *NS2*

Start Date: 8/07/14 **Start Qty:** 1.00 *1* **Cust Item ID:**

Required Date: 8/14/14 **Req'd Qty:** 1.00 *1* **Customer:**

Reference:

Run Start *NR1*

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Stop *NR2*

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
	dwg D2750 12- Deburr holes, ensure tube is free of all scratches before sending to paint.								
170 *170* QC Quality Control	QC10- Inspect visual per QSI004- ground welds	0.00							
	Memo	0.00	DAS 16 9-89 14/08/27						
180 *180* QC Quality Control	QC5- Inspect part completeness to step on W/O	0.00	DAS 16 9- 14/08/27						
	Memo ***VERIFY C'BOARD IS GOOD***	0.00							

14-8-21

AH

DART AEROSPACE

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date:

Work Order update only ☐

Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION

- Rework ☐
- Scrap ☐
- Use-as-is ☐
- Suspected Unapproved ☐

AGAINST DEPARTMENT/PROCESS

- Skid-tube ☐
- Machining ☐
- Thermoforming ☐
- Large Fab ☐
- Crosstube ☐
- Small Fab ☐
- Finishing ☐
- Composite ☐
- Water Jet ☐
- Prod. Eng. Coor. ☐
- Rec/Store/Packaging ☐
- Supplier ☐
- Engineering ☐
- Quality ☐
- Other ☐

Root Cause		Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design	☐									
Doc/Data	☐									
Equip/Tooling	☐									
Handling/Pre	☐									
Material	☐									
Operator	☐									
Offset/Setup	☐									
Process	☐									
Supplier	☐									
Training	☐									
Transport	☐									
Unapproved	☐									

FAULT CATEGORY

Landing Gear

- ☐ Bending
- ☐ Centre Not Concentric
- ☐ Cracks
- ☐ Crimp/Kink/Ripple/Wave
- ☐ Cuffs
- ☐ Crushing
- ☐ Heat Treat
- ☐ Inspection Strip in Tube
- ☐ Marks/Chatter
- ☐ Turning Sequence
- ☐ Wave/Twist in Tube

General

- ☐ Bend
- ☐ BOM/Route
- ☐ Broken/Damage/Defect
- ☐ Burrs
- ☐ Contamination
- ☐ Countersink
- ☐ Cut Too Short
- ☐ Drawing
- ☐ Drill Holes
- ☐ Finish
- ☐ Fit/Function
- ☐ Folio/Program
- ☐ Grain
- ☐ Hardware
- ☐ Inspection Incomplete/Unqualified
- ☐ Instructions Incomplete/Unclear
- ☐ Misaligned/off center
- ☐ Mislabeled
- ☐ Misread
- ☐ Off-set
- ☐ Out of Calibration
- ☐ Out of Sequence
- ☐ Outside Dimensions
- ☐ Over/Under tolerance
- ☐ Part Incorrect
- ☐ Part Lost/Missing
- ☐ Part Moved
- ☐ Positioned Wrong
- ☐ Power Loss/Surge
- ☐ Pressure/Forced
- ☐ Set-up
- ☐ Temperature/Cure
- ☐ Weld
- ☐ Wrong Stock Pulled
- ☐ Other

_____

_____

_____

Work Order ID 123262

August-06-14 9:02:06 AM

123262

Item ID: D350-636-012 **Accept** *N9000040100* **Setup Start** *NS1*

Revision ID:

Item Name: Skidtube RH Aerazur / Apical Cylindrical Compat. **Stop** *NS2*

Start Date: 8/07/14 **Start Qty:** 1.00 *1* **Cust Item ID:**

Required Date: 8/14/14 **Req'd Qty:** 1.00 *1* **Customer:**

Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____ **Run Start** *NR1*

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____ **Stop** *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190	Pressure Wash per QSI005 4.3	0.00							
190 HandFinish						1	Pb	14878	
	Memo	0.00							
Hand Finishing	Re-alodine tube as per QSI 005 section 4.1.2.1 do not acid etch.								
200		0.00							
200 SprayPaint						1			CR 14.08.30
	Memo	0.00							
Spray Painting	1- PRIME AS PER DWG AND QSI 005 4.2 PRIMER PRC DESOTO 515X349 BATCH: 129568 2- PAINT WHITE AS PER DWG AND QSI 005 4.2 PAINT BATCH: 129977								
210	QC14- Inspect Spray Paint	0.00							
210 QC						1373	0		14/09/02
	Memo	0.00							
Quality Control	Inspect for foreign object per QSI 024								

DART AEROSPACE

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date:

Work Order update only ☐

Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION

- Rework ☐
- Scrap ☐
- Use-as-is ☐
- Suspected Unapproved ☐

AGAINST DEPARTMENT/PROCESS

- Skid-tube ☐
- Machining ☐
- Thermoforming ☐
- Large Fab ☐
- Crosstube ☐
- Small Fab ☐
- Finishing ☐
- Composite ☐
- Water Jet ☐
- Prod. Eng. Coor. ☐
- Rec/Store/Packaging ☐
- Supplier ☐
- Engineering ☐
- Quality ☐
- Other ☐

Root Cause		Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design	☐									
Doc/Data	☐									
Equip/Tooling	☐									
Handling/Pre	☐									
Material	☐									
Operator	☐									
Offset/Setup	☐									
Process	☐									
Supplier	☐									
Training	☐									
Transport	☐									
Unapproved	☐									

FAULT CATEGORY

Landing Gear

- ☐ Bending
- ☐ Centre Not Concentric
- ☐ Cracks
- ☐ Crimp/Kink/Ripple/Wave
- ☐ Cuffs
- ☐ Crushing
- ☐ Heat Treat
- ☐ Inspection Strip in Tube
- ☐ Marks/Chatter
- ☐ Turning Sequence
- ☐ Wave/Twist in Tube

General

- ☐ Bend
- ☐ BOM/Route
- ☐ Broken/Damage/Defect
- ☐ Burrs
- ☐ Contamination
- ☐ Countersink
- ☐ Cut Too Short
- ☐ Drawing
- ☐ Drill Holes
- ☐ Finish
- ☐ Fit/Function
- ☐ Folio/Program
- ☐ Grain
- ☐ Hardware
- ☐ Inspection Incomplete/Unqualified
- ☐ Instructions Incomplete/Unclear
- ☐ Misaligned/off center
- ☐ Mislabeled
- ☐ Misread
- ☐ Off-set
- ☐ Out of Calibration
- ☐ Out of Sequence
- ☐ Outside Dimensions
- ☐ Over/Under tolerance
- ☐ Part Incorrect
- ☐ Part Lost/Missing
- ☐ Part Moved
- ☐ Positioned Wrong
- ☐ Power Loss/Surge
- ☐ Pressure/Forced
- ☐ Set-up
- ☐ Temperature/Cure
- ☐ Weld
- ☐ Wrong Stock Pulled
- ☐ Other

_____

_____

_____

Item ID: D350-636-012 **Accept** *N900040100* **Setup Start** *NS1*
Revision ID: **Stop** *NS2*
Item Name: Skidtube RH Aerazur / Apical Cylindrical Compat.
Start Date: 8/07/14 **Start Qty:** 1.00 *1* **Cust Item ID:**
Required Date: 8/14/14 **Req'd Qty:** 1.00 *1* **Customer:**
Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____ **Run Start** *NR1*
QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____ **Stop** *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
230		0.00							
230 HandFinish	HandFinishing					1RH	cl	01	14/09/ko
Hand Finishing	**Memo**	0.00							

1-Install inserts as per dwg D2750

2-Inspect for Foreign Objects

3-Install blade fitting D3488-042, wearshoes and ground handling hardware as per dwg D2750
SIKA FLEX 241
BATCH: M1129457
EXP DATE: 14/11

4-assemble o'ring to plug as per dwg D3492 and apply o'ring lube
A/R 55-o'ring lube batch: M1121651 1RTU 598 M1125792 exp 15/06

5-Coat all exposed fasteners with "LPS Procyon"
batch: M1127906

240	QC5- Inspect part completeness to step on W/O	0.00							DAS 38 9-89
240 QC	**Memo**	0.00				/			14-9-2 AS 15 -89
Quality Control									

DART AEROSPACE

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date:

Work Order update only ☐

Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION

- Rework ☐
- Scrap ☐
- Use-as-is ☐
- Suspected Unapproved ☐

AGAINST DEPARTMENT/PROCESS

- Skid-tube ☐
- Machining ☐
- Thermoforming ☐
- Large Fab ☐
- Crosstube ☐
- Small Fab ☐
- Finishing ☐
- Composite ☐
- Water Jet ☐
- Prod. Eng. Coor. ☐
- Rec/Store/Packaging ☐
- Supplier ☐
- Engineering ☐
- Quality ☐
- Other ☐

Root Cause		Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design	☐									
Doc/Data	☐									
Equip/Tooling	☐									
Handling/Pre	☐									
Material	☐									
Operator	☐									
Offset/Setup	☐									
Process	☐									
Supplier	☐									
Training	☐									
Transport	☐									
Unapproved	☐									

FAULT CATEGORY

Landing Gear

- ☐ Bending
- ☐ Centre Not Concentric
- ☐ Cracks
- ☐ Crimp/Kink/Ripple/Wave
- ☐ Cuffs
- ☐ Crushing
- ☐ Heat Treat
- ☐ Inspection Strip in Tube
- ☐ Marks/Chatter
- ☐ Turning Sequence
- ☐ Wave/Twist in Tube

General

- ☐ Bend
- ☐ BOM/Route
- ☐ Broken/Damage/Defect
- ☐ Burrs
- ☐ Contamination
- ☐ Countersink
- ☐ Cut Too Short
- ☐ Drawing
- ☐ Drill Holes
- ☐ Finish
- ☐ Fit/Function
- ☐ Folio/Program
- ☐ Grain
- ☐ Hardware
- ☐ Inspection Incomplete/Unqualified
- ☐ Instructions Incomplete/Unclear
- ☐ Misaligned/off center
- ☐ Mislabeled
- ☐ Misread
- ☐ Off-set
- ☐ Out of Calibration
- ☐ Out of Sequence
- ☐ Outside Dimensions
- ☐ Over/Under tolerance
- ☐ Part Incorrect
- ☐ Part Lost/Missing
- ☐ Part Moved
- ☐ Positioned Wrong
- ☐ Power Loss/Surge
- ☐ Pressure/Forced
- ☐ Set-up
- ☐ Temperature/Cure
- ☐ Weld
- ☐ Wrong Stock Pulled
- ☐ Other

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Work Order ID 123262

August-06-14 9:02:06 AM

123262

Item ID: D350-636-012

Revision ID:

Item Name: Skidtube RH Aerazur / Apical Cylindrical Compat.

Start Date: 8/07/14 **Start Qty:** 1.00 *1*

Required Date: 8/14/14 **Req'd Qty:** 1.00 *1*

Reference:

Accept *N9000040100*

Setup Start *NS1*

Stop *NS2*

Cust Item ID:

Customer:

Run Start *NR1*

Stop *NR2*

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
250	Pick Kit	0.00							DAS 32 9-89
250 Packaging						14/9/4	(1)		
Packaging	**Memo**	0.00							
260	QC4- 100% Inspect kits for completeness	0.00		DAS 06 9-89	SEP 04 2014				
260 QC	**Memo**	0.00							
Quality Control									
270		0.00		DAS 06 9-89	SEP 05 2014				
270 Packaging	Packaging								
Packaging	**Memo**	0.00	F6012						
	Package as per PPP D350-636-012								

DART AEROSPACE

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date:

Work Order update only ☐

Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION

- Rework ☐
- Scrap ☐
- Use-as-is ☐
- Suspected Unapproved ☐

AGAINST DEPARTMENT/PROCESS

- Skid-tube ☐
- Machining ☐
- Thermoforming ☐
- Large Fab ☐
- Crosstube ☐
- Small Fab ☐
- Finishing ☐
- Composite ☐
- Water Jet ☐
- Prod. Eng. Coor. ☐
- Rec/Store/Packaging ☐
- Supplier ☐
- Engineering ☐
- Quality ☐
- Other ☐

Root Cause		Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design	☐									
Doc/Data	☐									
Equip/Tooling	☐									
Handling/Pre	☐									
Material	☐									
Operator	☐									
Offset/Setup	☐									
Process	☐									
Supplier	☐									
Training	☐									
Transport	☐									
Unapproved	☐									

FAULT CATEGORY

Landing Gear

- ☐ Bending
- ☐ Centre Not Concentric
- ☐ Cracks
- ☐ Crimp/Kink/Ripple/Wave
- ☐ Cuffs
- ☐ Crushing
- ☐ Heat Treat
- ☐ Inspection Strip in Tube
- ☐ Marks/Chatter
- ☐ Turning Sequence
- ☐ Wave/Twist in Tube

General

- ☐ Bend
- ☐ BOM/Route
- ☐ Broken/Damage/Defect
- ☐ Burrs
- ☐ Contamination
- ☐ Countersink
- ☐ Cut Too Short
- ☐ Drawing
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- ☐ Finish
- ☐ Fit/Function
- ☐ Folio/Program
- ☐ Grain
- ☐ Hardware
- ☐ Inspection Incomplete/Unqualified
- ☐ Instructions Incomplete/Unclear
- ☐ Misaligned/off center
- ☐ Mislabeled
- ☐ Misread
- ☐ Off-set
- ☐ Out of Calibration
- ☐ Out of Sequence
- ☐ Outside Dimensions
- ☐ Over/Under tolerance
- ☐ Part Incorrect
- ☐ Part Lost/Missing
- ☐ Part Moved
- ☐ Positioned Wrong
- ☐ Power Loss/Surge
- ☐ Pressure/Forced
- ☐ Set-up
- ☐ Temperature/Cure
- ☐ Weld
- ☐ Wrong Stock Pulled
- ☐ Other

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Work Order ID 123262

August-06-14 9:02:06 AM

123262

Item ID: D350-636-012

Revision ID:

Item Name: Skidtube RH Aerazur / Apical Cylindrical Compat.

Accept *N9000040100*

Setup Start *NS1*

Stop *NS2*

Start Date: 8/07/14 **Start Qty:** 1.00 *1*

Required Date: 8/14/14 **Req'd Qty:** 1.00 *1*

Reference:

Cust Item ID:

Customer:

Run Start *NR1*

Stop *NR2*

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
280	QC21- Final Inspection - Work Order Release	0.00							
280						MLJ		14-09-05	
QC	Memo	0.00							
Quality Control									

U 14.09.05

DART AEROSPACE

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date:

Work Order update only ☐

Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION

- Rework ☐
- Scrap ☐
- Use-as-is ☐
- Suspected Unapproved ☐

AGAINST DEPARTMENT/PROCESS

- Skid-tube ☐
- Machining ☐
- Thermoforming ☐
- Large Fab ☐
- Crosstube ☐
- Small Fab ☐
- Finishing ☐
- Composite ☐
- Water Jet ☐
- Prod. Eng. Coor. ☐
- Rec/Store/Packaging ☐
- Supplier ☐
- Engineering ☐
- Quality ☐
- Other ☐

Root Cause		Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design	☐									
Doc/Data	☐									
Equip/Tooling	☐									
Handling/Pre	☐									
Material	☐									
Operator	☐									
Offset/Setup	☐									
Process	☐									
Supplier	☐									
Training	☐									
Transport	☐									
Unapproved	☐									

FAULT CATEGORY

Landing Gear

- ☐ Bending
- ☐ Centre Not Concentric
- ☐ Cracks
- ☐ Crimp/Kink/Ripple/Wave
- ☐ Cuffs
- ☐ Crushing
- ☐ Heat Treat
- ☐ Inspection Strip in Tube
- ☐ Marks/Chatter
- ☐ Turning Sequence
- ☐ Wave/Twist in Tube

General

- ☐ Bend
- ☐ BOM/Route
- ☐ Broken/Damage/Defect
- ☐ Burrs
- ☐ Contamination
- ☐ Countersink
- ☐ Cut Too Short
- ☐ Drawing
- ☐ Drill Holes
- ☐ Finish
- ☐ Fit/Function
- ☐ Folio/Program
- ☐ Grain
- ☐ Hardware
- ☐ Inspection Incomplete/Unqualified
- ☐ Instructions Incomplete/Unclear
- ☐ Misaligned/off center
- ☐ Mislabeled
- ☐ Misread
- ☐ Off-set
- ☐ Out of Calibration
- ☐ Out of Sequence
- ☐ Outside Dimensions
- ☐ Over/Under tolerance
- ☐ Part Incorrect
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- ☐ Power Loss/Surge
- ☐ Pressure/Forced
- ☐ Set-up
- ☐ Temperature/Cure
- ☐ Weld
- ☐ Wrong Stock Pulled
- ☐ Other

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Picklist Print

August-06-14 9:02:13 AM

13

Work Order ID: 123262 *123262*

Parent Item: D350-636-012 *D350-636-012*

Parent Item Name: Skidtube RH Aerazur / Apical Cylindrical Compat.

Start Date: 8/07/14 **Required Date:** 8/14/14

Start Qty: 1.00 **Required Qty:** 1.00

Comments: IPP Rev:I02.09.25Rearranged procedure stepsKJ
IPP Rev:J 06-03-29 As per Rev D EC IPP REV:K
AS PER REV F JLM 13-08-22 VERIFIED BY:DD
IPP Rev:K 06-07.13 As per dsi9343 EC
IPP Rev:L 07-07-28 Added SS Wearplates(Rev E) JLM Verified By:EC
IPP Rev:M 08-04-22 update steps 4,13 DD verified by:EC
IPP Rev:N 08-09-23 revF as per dwg DD verified by:ec IPP Rev:O
10.06.22 revise seq110 DD verf:EC IPP Rev:P 10.10.01 as
per IIN revH DD verf:EC IPP REV:Q 13.08.27 PER ECN13-
594 DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2600-3-BENT		Manufactured	No			110	Each	11.0000	1	1			
D2600-3-BENT									**				
Extrusion Bent													

Location	Loc Qty	Loc Code
LG002	11	
119680	10	
120571	1	

DGC 14-8-14.

D2744		Manufactured	No			110	Each	63.0000	1	1			
D2744									**			8-14-08-14	
Cap													

Location	Loc Qty	Loc Code
LG001	63	
113128	56	
115440	7	

DART AEROSPACE

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date:

Work Order update only ☐

Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION

- Rework ☐
- Scrap ☐
- Use-as-is ☐
- Suspected Unapproved ☐

AGAINST DEPARTMENT/PROCESS

- Skid-tube ☐
- Machining ☐
- Thermoforming ☐
- Large Fab ☐
- Crosstube ☐
- Small Fab ☐
- Finishing ☐
- Composite ☐
- Water Jet ☐
- Prod. Eng. Coor. ☐
- Rec/Store/Packaging ☐
- Supplier ☐
- Engineering ☐
- Quality ☐
- Other ☐

Root Cause		Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design	☐									
Doc/Data	☐									
Equip/Tooling	☐									
Handling/Pre	☐									
Material	☐									
Operator	☐									
Offset/Setup	☐									
Process	☐									
Supplier	☐									
Training	☐									
Transport	☐									
Unapproved	☐									

FAULT CATEGORY

Landing Gear

- ☐ Bending
- ☐ Centre Not Concentric
- ☐ Cracks
- ☐ Crimp/Kink/Ripple/Wave
- ☐ Cuffs
- ☐ Crushing
- ☐ Heat Treat
- ☐ Inspection Strip in Tube
- ☐ Marks/Chatter
- ☐ Turning Sequence
- ☐ Wave/Twist in Tube

General

- ☐ Bend
- ☐ BOM/Route
- ☐ Broken/Damage/Defect
- ☐ Burrs
- ☐ Contamination
- ☐ Countersink
- ☐ Cut Too Short
- ☐ Drawing
- ☐ Drill Holes
- ☐ Finish
- ☐ Fit/Function
- ☐ Folio/Program
- ☐ Grain
- ☐ Hardware
- ☐ Inspection Incomplete/Unqualified
- ☐ Instructions Incomplete/Unclear
- ☐ Misaligned/off center
- ☐ Mislabeled
- ☐ Misread
- ☐ Off-set
- ☐ Out of Calibration
- ☐ Out of Sequence
- ☐ Outside Dimensions
- ☐ Over/Under tolerance
- ☐ Part Incorrect
- ☐ Part Lost/Missing
- ☐ Part Moved
- ☐ Positioned Wrong
- ☐ Power Loss/Surge
- ☐ Pressure/Forced
- ☐ Set-up
- ☐ Temperature/Cure
- ☐ Weld
- ☐ Wrong Stock Pulled
- ☐ Other

_____

_____

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Picklist Print

August-06-14 9:02:13 AM

Work Order ID: 123262 *123262*

Parent Item: D350-636-012 *D350-636-012*

Parent Item Name: Skidtube RH Aerazur / Apical Cylindrical Compat.

Start Date: 8/07/14 **Required Date:** 8/14/14

Start Qty: 1.00 **Required Qty:** 1.00

D2739 Manufactured No 160 Each 13.0000 1 1

D2739

350 I Beam

** DP 14-8-18

Location	Loc Qty	Loc Code
LG002 120580	13	
117245	2	
117803	1	
120580	10	

D2743 Manufactured No 160 Each 272.0000 8 8

D2743

Crossbolt Spacer

** BE14-08-19

Location	Loc Qty	Loc Code
LG001	272	
109799	1	
112729	59	
119609	130	
120481	82	

D3490-3 Manufactured No 160 Each 22.0000 4 4

D3490-3

Cross Bolt Spacer

** BE14-08-19

B122458 x2

Location	Loc Qty	Loc Code
LG001	22	
117249	22	

D3490-1 Manufactured No 160 Each 55.0000 4 4

D3490-1

Cross Bolt Spacer

** BE14-08-19

Location	Loc Qty	Loc Code
LG001	55	
112737	1	
116358	54	

DART AEROSPACE

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date:

Work Order update only ☐

Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION

- Rework ☐
- Scrap ☐
- Use-as-is ☐
- Suspected Unapproved ☐

AGAINST DEPARTMENT/PROCESS

- Skid-tube ☐
- Machining ☐
- Thermoforming ☐
- Large Fab ☐
- Crosstube ☐
- Small Fab ☐
- Finishing ☐
- Composite ☐
- Water Jet ☐
- Prod. Eng. Coor. ☐
- Rec/Store/Packaging ☐
- Supplier ☐
- Engineering ☐
- Quality ☐
- Other ☐

Root Cause		Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design	☐									
Doc/Data	☐									
Equip/Tooling	☐									
Handling/Pre	☐									
Material	☐									
Operator	☐									
Offset/Setup	☐									
Process	☐									
Supplier	☐									
Training	☐									
Transport	☐									
Unapproved	☐									

FAULT CATEGORY

Landing Gear

- ☐ Bending
- ☐ Centre Not Concentric
- ☐ Cracks
- ☐ Crimp/Kink/Ripple/Wave
- ☐ Cuffs
- ☐ Crushing
- ☐ Heat Treat
- ☐ Inspection Strip in Tube
- ☐ Marks/Chatter
- ☐ Turning Sequence
- ☐ Wave/Twist in Tube

General

- ☐ Bend
- ☐ BOM/Route
- ☐ Broken/Damage/Defect
- ☐ Burrs
- ☐ Contamination
- ☐ Countersink
- ☐ Cut Too Short
- ☐ Drawing
- ☐ Drill Holes
- ☐ Finish
- ☐ Fit/Function
- ☐ Folio/Program
- ☐ Grain
- ☐ Hardware
- ☐ Inspection Incomplete/Unqualified
- ☐ Instructions Incomplete/Unclear
- ☐ Misaligned/off center
- ☐ Mislabeled
- ☐ Misread
- ☐ Off-set
- ☐ Out of Calibration
- ☐ Out of Sequence
- ☐ Outside Dimensions
- ☐ Over/Under tolerance
- ☐ Part Incorrect
- ☐ Part Lost/Missing
- ☐ Part Moved
- ☐ Positioned Wrong
- ☐ Power Loss/Surge
- ☐ Pressure/Forced
- ☐ Set-up
- ☐ Temperature/Cure
- ☐ Weld
- ☐ Wrong Stock Pulled
- ☐ Other

_____

_____

_____

Picklist Print

August-06-14 9:02:13 AM

Work Order ID: 123262 *123262*

Parent Item: D350-636-012 *D350-636-012*

Parent Item Name: Skidtube RH Aerazur / Apical Cylindrical Compat.

Start Date: 8/07/14 **Required Date:** 8/14/14

Start Qty: 1.00 **Required Qty:** 1.00

D3631-1	Manufactured	No	230	Each	152.0000	8	8	
D3631-1 Washer						**		11/09/02

Location		Loc Qty	Loc Code	
FP001		152		
	110258	16		
	119553	36		
	120410	100		x 8

D3791-1	Manufactured	No	230	Each	1.0000	1	1	
D3791-1 Wearpad						**		11/09/02

Location		Loc Qty	Loc Code	
FP001		1	13118942	x 1
	92689	1		

D3793-3	Manufactured	No	230	Each	24.0000	1	1	
D3793-3 Wearplate Aft						**		11/09/02

Location		Loc Qty	Loc Code	
FP001		1		
	104212	1		
FP002		23		
	116781	11		x 1
	120141	12		

DART AEROSPACE

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date:

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	**DISPOSITION** Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	**AGAINST DEPARTMENT/PROCESS** Skid-tube ☐ Crosstube ☐ Water Jet ☐ Engineering ☐ Machining ☐ Small Fab ☐ Prod. Eng. Coor. ☐ Quality ☐ Thermoforming ☐ Finishing ☐ Rec/Store/Packaging ☐ Other ☐ Large Fab ☐ Composite ☐ Supplier ☐ ☐

Root Cause		Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design	☐									
Doc/Data	☐									
Equip/Tooling	☐									
Handling/Pre	☐									
Material	☐									
Operator	☐									
Offset/Setup	☐									
Process	☐									
Supplier	☐									
Training	☐									
Transport	☐									
Unapproved	☐									

FAULT CATEGORY

Landing Gear

- ☐ Bending
- ☐ Centre Not Concentric
- ☐ Cracks
- ☐ Crimp/Kink/Ripple/Wave
- ☐ Cuffs
- ☐ Crushing
- ☐ Heat Treat
- ☐ Inspection Strip in Tube
- ☐ Marks/Chatter
- ☐ Turning Sequence
- ☐ Wave/Twist in Tube

General

- ☐ Bend
- ☐ BOM/Route
- ☐ Broken/Damage/Defect
- ☐ Burrs
- ☐ Contamination
- ☐ Countersink
- ☐ Cut Too Short
- ☐ Drawing
- ☐ Drill Holes
- ☐ Finish
- ☐ Fit/Function
- ☐ Folio/Program
- ☐ Grain
- ☐ Hardware
- ☐ Inspection Incomplete/Unqualified
- ☐ Instructions Incomplete/Unclear
- ☐ Misaligned/off center
- ☐ Mislabeled
- ☐ Misread
- ☐ Off-set
- ☐ Out of Calibration
- ☐ Out of Sequence
- ☐ Outside Dimensions
- ☐ Over/Under tolerance
- ☐ Part Incorrect
- ☐ Part Lost/Missing
- ☐ Part Moved
- ☐ Positioned Wrong
- ☐ Power Loss/Surge
- ☐ Pressure/Forced
- ☐ Set-up
- ☐ Temperature/Cure
- ☐ Weld
- ☐ Wrong Stock Pulled
- ☐ Other

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Picklist Print

August-06-14 9:02:13 AM

Work Order ID: 123262 *123262*

Parent Item: D350-636-012 *D350-636-012*

Parent Item Name: Skidtube RH Aerazur / Apical Cylindrical Compat.

Start Date: 8/07/14 **Required Date:** 8/14/14

Start Qty: 1.00 **Required Qty:** 1.00

MS21043-6	Purchased	No	230	Each	124.0000	4	4	
MS21043-6 NUT						**		ll 11/09/02

Location	Loc Qty	Loc Code	
FG	20		
103693	20		
ST306	104		
m127255	6		
m127813	98		X 4

D3794-1	Manufactured	No	230	Each	17.0000	1	1	
D3794-1 Gasket Fwd						**		ll 11/09/02

Location	Loc Qty	Loc Code	
FP001	17		
109207	1		
115838	3		
119625	12		X1
93381	1		

NAS1611-010	Purchased	No	230	Each	511.0000	8	8	
NAS1611-010 O-RING						**		ll 11/09/02

Location	Loc Qty	Loc Code	
FP001	511		
m126988	3		
m127813	4		
m128375	10		
m128388	8		
m129198	44		
m129405	82		
m129523	360		X 8

DART AEROSPACE

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date:

Work Order update only ☐

Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION

- Rework ☐
- Scrap ☐
- Use-as-is ☐
- Suspected Unapproved ☐

AGAINST DEPARTMENT/PROCESS

- Skid-tube ☐
- Machining ☐
- Thermoforming ☐
- Large Fab ☐
- Crosstube ☐
- Small Fab ☐
- Finishing ☐
- Composite ☐
- Water Jet ☐
- Prod. Eng. Coor. ☐
- Rec/Store/Packaging ☐
- Supplier ☐
- Engineering ☐
- Quality ☐
- Other ☐

Root Cause		Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design	☐									
Doc/Data	☐									
Equip/Tooling	☐									
Handling/Pre	☐									
Material	☐									
Operator	☐									
Offset/Setup	☐									
Process	☐									
Supplier	☐									
Training	☐									
Transport	☐									
Unapproved	☐									

FAULT CATEGORY

Landing Gear

- ☐ Bending
- ☐ Centre Not Concentric
- ☐ Cracks
- ☐ Crimp/Kink/Ripple/Wave
- ☐ Cuffs
- ☐ Crushing
- ☐ Heat Treat
- ☐ Inspection Strip in Tube
- ☐ Marks/Chatter
- ☐ Turning Sequence
- ☐ Wave/Twist in Tube

General

- ☐ Bend
- ☐ BOM/Route
- ☐ Broken/Damage/Defect
- ☐ Burrs
- ☐ Contamination
- ☐ Countersink
- ☐ Cut Too Short
- ☐ Drawing
- ☐ Drill Holes
- ☐ Finish
- ☐ Fit/Function
- ☐ Folio/Program
- ☐ Grain
- ☐ Hardware
- ☐ Inspection Incomplete/Unqualified
- ☐ Instructions Incomplete/Unclear
- ☐ Misaligned/off center
- ☐ Mislabeled
- ☐ Misread
- ☐ Off-set
- ☐ Out of Calibration
- ☐ Out of Sequence
- ☐ Outside Dimensions
- ☐ Over/Under tolerance
- ☐ Part Incorrect
- ☐ Part Lost/Missing
- ☐ Part Moved
- ☐ Positioned Wrong
- ☐ Power Loss/Surge
- ☐ Pressure/Forced
- ☐ Set-up
- ☐ Temperature/Cure
- ☐ Weld
- ☐ Wrong Stock Pulled
- ☐ Other

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Picklist Print

August-06-14 9:02:13 AM

Work Order ID: 123262 *123262*

Parent Item: D350-636-012 *D350-636-012*

Parent Item Name: Skidtube RH Aerazur / Apical Cylindrical Compat.

Start Date: 8/07/14 **Required Date:** 8/14/14

Start Qty: 1.00 **Required Qty:** 1.00

D2741	Manufactured	No	250	Each	71.0000	1	1	
D2741						**	B118337	DAS 32 9-89
Blade								

Location		Loc Qty	Loc Code
FG		10	
	100664	5	
	113640	2	
	115522	3	
ST538		61	
	118387	61	

DAS 06 9-89

NAS1515H3L	Purchased	No	230	Each	391.0000	4	4	
NAS1515H3L						**		11/09/02
Washer								

Location		Loc Qty	Loc Code
FG		40	
	102472	40	
ST273		351	
	m127831	144	
	m128976	207	

NAS1611-013	Purchased	No	230	Each	260.0000	8	8	
NAS1611-013						**		11/09/02
O-RING								

Location		Loc Qty	Loc Code
FP001		260	
	m128375	72	
	m129430	188	

DART AEROSPACE

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date:

Work Order update only ☐

Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION

- Rework ☐
- Scrap ☐
- Use-as-is ☐
- Suspected Unapproved ☐

AGAINST DEPARTMENT/PROCESS

Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐
Machining ☐	Small Fab ☐	Prod. Eng. Coor. ☐	Quality ☐
Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐
Large Fab ☐	Composite ☐	Supplier ☐	☐

Root Cause		Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design	☐									
Doc/Data	☐									
Equip/Tooling	☐									
Handling/Pre	☐									
Material	☐									
Operator	☐									
Offset/Setup	☐									
Process	☐									
Supplier	☐									
Training	☐									
Transport	☐									
Unapproved	☐									

FAULT CATEGORY

Landing Gear

- ☐ Bending
- ☐ Centre Not Concentric
- ☐ Cracks
- ☐ Crimp/Kink/Ripple/Wave
- ☐ Cuffs
- ☐ Crushing
- ☐ Heat Treat
- ☐ Inspection Strip in Tube
- ☐ Marks/Chatter
- ☐ Turning Sequence
- ☐ Wave/Twist in Tube

General

- ☐ Bend
- ☐ BOM/Route
- ☐ Broken/Damage/Defect
- ☐ Burrs
- ☐ Contamination
- ☐ Countersink
- ☐ Cut Too Short
- ☐ Drawing
- ☐ Drill Holes
- ☐ Finish
- ☐ Fit/Function
- ☐ Folio/Program
- ☐ Grain
- ☐ Hardware
- ☐ Inspection Incomplete/Unqualified
- ☐ Instructions Incomplete/Unclear
- ☐ Misaligned/off center
- ☐ Mislabeled
- ☐ Misread
- ☐ Off-set
- ☐ Out of Calibration
- ☐ Out of Sequence
- ☐ Outside Dimensions
- ☐ Over/Under tolerance
- ☐ Part Incorrect
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- ☐ Power Loss/Surge
- ☐ Pressure/Forced
- ☐ Set-up
- ☐ Temperature/Cure
- ☐ Weld
- ☐ Wrong Stock Pulled
- ☐ Other

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Picklist Print

August-06-14 9:02:13 AM

Work Order ID: 123262 *123262*

Parent Item: D350-636-012 *D350-636-012*

Parent Item Name: Skidtube RH Aerazur / Apical Cylindrical Compat.

Start Date: 8/07/14 **Required Date:** 8/14/14

Start Qty: 1.00 **Required Qty:** 1.00

AN3C6A Purchased No 230 Each 1,132.000 4 4

AN3C6A ** ll 14/09/02

Bolt

Location		Loc Qty	Loc Code	
FG		10		
	122416	10		
ST513		1122		
	m125709	126		x4
	m128769	996		

NAS1149C0832R Purchased No 230 Each 274.0000 1 1

NAS1149C0832R ** ll 14/09/02

Washer

Location		Loc Qty	Loc Code	
ST277		274		
	122441	7		
	m114915	117		x1
	m125807	150		

D3536-25 Manufactured No 230 Each 18.0000 1 1

D3536-25 ** ll 14/09/02

Gasket Center

Location		Loc Qty	Loc Code	
FG		6		
	87053	2		
	95328	4		
FP001		12		
	110652	1		
	120084	10		V1
	93696	1		

DART AEROSPACE

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date:

Work Order update only ☐

Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION

- Rework ☐
- Scrap ☐
- Use-as-is ☐
- Suspected Unapproved ☐

AGAINST DEPARTMENT/PROCESS

- Skid-tube ☐
- Machining ☐
- Thermoforming ☐
- Large Fab ☐
- Crosstube ☐
- Small Fab ☐
- Finishing ☐
- Composite ☐
- Water Jet ☐
- Prod. Eng. Coor. ☐
- Rec/Store/Packaging ☐
- Supplier ☐
- Engineering ☐
- Quality ☐
- Other ☐

Root Cause		Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design	☐									
Doc/Data	☐									
Equip/Tooling	☐									
Handling/Pre	☐									
Material	☐									
Operator	☐									
Offset/Setup	☐									
Process	☐									
Supplier	☐									
Training	☐									
Transport	☐									
Unapproved	☐									

FAULT CATEGORY

Landing Gear

- ☐ Bending
- ☐ Centre Not Concentric
- ☐ Cracks
- ☐ Crimp/Kink/Ripple/Wave
- ☐ Cuffs
- ☐ Crushing
- ☐ Heat Treat
- ☐ Inspection Strip in Tube
- ☐ Marks/Chatter
- ☐ Turning Sequence
- ☐ Wave/Twist in Tube

General

- ☐ Bend
- ☐ BOM/Route
- ☐ Broken/Damage/Defect
- ☐ Burrs
- ☐ Contamination
- ☐ Countersink
- ☐ Cut Too Short
- ☐ Drawing
- ☐ Drill Holes
- ☐ Finish
- ☐ Fit/Function
- ☐ Folio/Program
- ☐ Grain
- ☐ Hardware
- ☐ Inspection Incomplete/Unqualified
- ☐ Instructions Incomplete/Unclear
- ☐ Misaligned/off center
- ☐ Mislabeled
- ☐ Misread
- ☐ Off-set
- ☐ Out of Calibration
- ☐ Out of Sequence
- ☐ Outside Dimensions
- ☐ Over/Under tolerance
- ☐ Part Incorrect
- ☐ Part Lost/Missing
- ☐ Part Moved
- ☐ Positioned Wrong
- ☐ Power Loss/Surge
- ☐ Pressure/Forced
- ☐ Set-up
- ☐ Temperature/Cure
- ☐ Weld
- ☐ Wrong Stock Pulled
- ☐ Other

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Picklist Print

August-06-14 9:02:13 AM

Work Order ID: 123262 *123262*

Parent Item: D350-636-012 *D350-636-012*

Parent Item Name: Skidtube RH Aerazur / Apical Cylindrical Compat.

Start Date: 8/07/14 **Required Date:** 8/14/14

Start Qty: 1.00 **Required Qty:** 1.00

D3794-3	Manufactured	No	230	Each	26.0000	1	1	
D3794-3						**		ll 10/09/07
Gasket Aft								

Location	Loc Qty	Loc Code	
FP001	26		
111457	8		
119388	5		
122529	12		X1
92658	1		

AN3C5A	Purchased	No	230	Each	745.0000	34	34	
AN3C5A						**		ll 10/09/07
Bolt								

Location	Loc Qty	Loc Code	
FG	5		
122800	5		
ST350	740		
M128911	530		X34
M128973	10		
M129913	200		

D3537-1	Manufactured	No	230	Each	114.0000	3	3	
D3537-1						**		ll 10/09/07
Wearpad								

Location	Loc Qty	Loc Code	
FG	18		
79833	8		
88562	10		
FP001	96		
113839	4		
120545	31		
120645	60		X3
93945	1		

DART AEROSPACE

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date:

Work Order update only ☐

Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION

- Rework ☐
- Scrap ☐
- Use-as-is ☐
- Suspected Unapproved ☐

AGAINST DEPARTMENT/PROCESS

- Skid-tube ☐
- Machining ☐
- Thermoforming ☐
- Large Fab ☐
- Crosstube ☐
- Small Fab ☐
- Finishing ☐
- Composite ☐
- Water Jet ☐
- Prod. Eng. Coor. ☐
- Rec/Store/Packaging ☐
- Supplier ☐
- Engineering ☐
- Quality ☐
- Other ☐

Root Cause		Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design	☐									
Doc/Data	☐									
Equip/Tooling	☐									
Handling/Pre	☐									
Material	☐									
Operator	☐									
Offset/Setup	☐									
Process	☐									
Supplier	☐									
Training	☐									
Transport	☐									
Unapproved	☐									

FAULT CATEGORY

Landing Gear

- ☐ Bending
- ☐ Centre Not Concentric
- ☐ Cracks
- ☐ Crimp/Kink/Ripple/Wave
- ☐ Cuffs
- ☐ Crushing
- ☐ Heat Treat
- ☐ Inspection Strip in Tube
- ☐ Marks/Chatter
- ☐ Turning Sequence
- ☐ Wave/Twist in Tube

General

- ☐ Bend
- ☐ BOM/Route
- ☐ Broken/Damage/Defect
- ☐ Burrs
- ☐ Contamination
- ☐ Countersink
- ☐ Cut Too Short
- ☐ Drawing
- ☐ Drill Holes
- ☐ Finish
- ☐ Fit/Function
- ☐ Folio/Program
- ☐ Grain
- ☐ Hardware
- ☐ Inspection Incomplete/Unqualified
- ☐ Instructions Incomplete/Unclear
- ☐ Misaligned/off center
- ☐ Mislabeled
- ☐ Misread
- ☐ Off-set
- ☐ Out of Calibration
- ☐ Out of Sequence
- ☐ Outside Dimensions
- ☐ Over/Under tolerance
- ☐ Part Incorrect
- ☐ Part Lost/Missing
- ☐ Part Moved
- ☐ Positioned Wrong
- ☐ Power Loss/Surge
- ☐ Pressure/Forced
- ☐ Set-up
- ☐ Temperature/Cure
- ☐ Weld
- ☐ Wrong Stock Pulled
- ☐ Other

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Picklist Print

August-06-14 9:02:13 AM

Work Order ID: 123262 *123262*

Parent Item: D350-636-012 *D350-636-012*

Parent Item Name: Skidtube RH Aerazur / Apical Cylindrical Compat.

Start Date: 8/07/14 **Required Date:** 8/14/14

Start Qty: 1.00 **Required Qty:** 1.00

D3535-25 Manufactured No 230 Each 15.0000 1 1

D3535-25 ** 14/09/02

Wearplate Center

Location		Loc Qty	Loc Code	
FG		2		
	95077	2		
FP002		13		
	110744	1		
	118933	11		X
	93278	1		

D3492-3 Manufactured No 230 Each 162.0000 8 8

D3492-3 ** 14/09/02

Plug

Location		Loc Qty	Loc Code	
FP001		162		
	104853	24		
	107331	1		
	112739	1		
	115807	30		
	118977	106		X

DART AEROSPACE

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date:

Work Order update only ☐

Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION

- Rework ☐
- Scrap ☐
- Use-as-is ☐
- Suspected Unapproved ☐

AGAINST DEPARTMENT/PROCESS

- Skid-tube ☐
- Machining ☐
- Thermoforming ☐
- Large Fab ☐
- Crosstube ☐
- Small Fab ☐
- Finishing ☐
- Composite ☐
- Water Jet ☐
- Prod. Eng. Coor. ☐
- Rec/Store/Packaging ☐
- Supplier ☐
- Engineering ☐
- Quality ☐
- Other ☐

Root Cause		Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design	☐									
Doc/Data	☐									
Equip/Tooling	☐									
Handling/Pre	☐									
Material	☐									
Operator	☐									
Offset/Setup	☐									
Process	☐									
Supplier	☐									
Training	☐									
Transport	☐									
Unapproved	☐									

FAULT CATEGORY

Landing Gear

- ☐ Bending
- ☐ Centre Not Concentric
- ☐ Cracks
- ☐ Crimp/Kink/Ripple/Wave
- ☐ Cuffs
- ☐ Crushing
- ☐ Heat Treat
- ☐ Inspection Strip in Tube
- ☐ Marks/Chatter
- ☐ Turning Sequence
- ☐ Wave/Twist in Tube

General

- ☐ Bend
- ☐ BOM/Route
- ☐ Broken/Damage/Defect
- ☐ Burrs
- ☐ Contamination
- ☐ Countersink
- ☐ Cut Too Short
- ☐ Drawing
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- ☐ Folio/Program
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- ☐ Inspection Incomplete/Unqualified
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- ☐ Out of Calibration
- ☐ Out of Sequence
- ☐ Outside Dimensions
- ☐ Over/Under tolerance
- ☐ Part Incorrect
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- ☐ Power Loss/Surge
- ☐ Pressure/Forced
- ☐ Set-up
- ☐ Temperature/Cure
- ☐ Weld
- ☐ Wrong Stock Pulled
- ☐ Other

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Picklist Print

August-06-14 9:02:13 AM

Work Order ID: 123262 *123262*

Parent Item: D350-636-012 *D350-636-012*

Parent Item Name: Skidtube RH Aerazur / Apical Cylindrical Compat.

Start Date: 8/07/14 **Required Date:** 8/14/14

Start Qty: 1.00 **Required Qty:** 1.00

NAS1149C0332R	Purchased	No	230	Each	5,151.000	38	38	
NAS1149C0332R						**		
WASHER								

Location		Loc Qty	Loc Code	
CA		83		
	m129682	83		
ST278		5068		
	122063	41		
	125654	609		
	m126319	61		
	m127306	2500		
	m127410	543		X38
	m127831	26		
	m128591	75		
	m129390	146		
	m129499	183		
	m129909	884		

D3488-042	Manufactured	No	230	Each	24.0000	1	1	
D3488-042						**		
Blade Fitting RH								

Location		Loc Qty	Loc Code	
FP001		22		
	115599	10		
	120135	11		✓ 1
	98887	1		
FP002		2		
	112237	2		

DART AEROSPACE

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date:

Work Order update only ☐

Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION

- Rework ☐
- Scrap ☐
- Use-as-is ☐
- Suspected Unapproved ☐

AGAINST DEPARTMENT/PROCESS

- Skid-tube ☐
- Machining ☐
- Thermoforming ☐
- Large Fab ☐
- Crosstube ☐
- Small Fab ☐
- Finishing ☐
- Composite ☐
- Water Jet ☐
- Prod. Eng. Coor. ☐
- Rec/Store/Packaging ☐
- Supplier ☐
- Engineering ☐
- Quality ☐
- Other ☐

Root Cause		Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design	☐									
Doc/Data	☐									
Equip/Tooling	☐									
Handling/Pre	☐									
Material	☐									
Operator	☐									
Offset/Setup	☐									
Process	☐									
Supplier	☐									
Training	☐									
Transport	☐									
Unapproved	☐									

FAULT CATEGORY

Landing Gear

- ☐ Bending
- ☐ Centre Not Concentric
- ☐ Cracks
- ☐ Crimp/Kink/Ripple/Wave
- ☐ Cuffs
- ☐ Crushing
- ☐ Heat Treat
- ☐ Inspection Strip in Tube
- ☐ Marks/Chatter
- ☐ Turning Sequence
- ☐ Wave/Twist in Tube

General

- ☐ Bend
- ☐ BOM/Route
- ☐ Broken/Damage/Defect
- ☐ Burrs
- ☐ Contamination
- ☐ Countersink
- ☐ Cut Too Short
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- ☐ Grain
- ☐ Hardware
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- ☐ Power Loss/Surge
- ☐ Pressure/Forced
- ☐ Set-up
- ☐ Temperature/Cure
- ☐ Weld
- ☐ Wrong Stock Pulled
- ☐ Other

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Picklist Print

August-06-14 9:02:13 AM

Work Order ID: 123262 *123262*

Parent Item: D350-636-012 *D350-636-012*

Parent Item Name: Skidtube RH Aerazur / Apical Cylindrical Compat.

Start Date: 8/07/14 **Required Date:** 8/14/14

Start Qty: 1.00 **Required Qty:** 1.00

ALS4-1032-225	AELS8-1032-225	Purchased	No	230	Each	409.0000	38	38		
ALS4-1032-225							**			
Rivnut ALS7-1032-225										

Location	Loc Qty	Loc Code	
FG	30		
M127028	30		
ST267	379		
M127028	10		
M127092	26		
M128179	330		
M128649	13		x38

D3492-1		Manufactured	No	230	Each	249.0000	8	8		
D3492-1							**			
Plug										

Location	Loc Qty	Loc Code	
FP001	249		
111578	2		
114879	13		
119646	34		
120519	60		
122460	60		
122712	80		x8

D3793-1		Manufactured	No	230	Each	26.0000	1	1		
D3793-1							**			
Wearplate Fwd										

Location	Loc Qty	Loc Code	
FP002	26		
112741	2		
116846	11		
~~120212~~	12		x1
92382	1		

DART AEROSPACE

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date:

Work Order update only ☐

Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION

- Rework ☐
- Scrap ☐
- Use-as-is ☐
- Suspected Unapproved ☐

AGAINST DEPARTMENT/PROCESS

- Skid-tube ☐
- Machining ☐
- Thermoforming ☐
- Large Fab ☐
- Crosstube ☐
- Small Fab ☐
- Finishing ☐
- Composite ☐
- Water Jet ☐
- Prod. Eng. Coor. ☐
- Rec/Store/Packaging ☐
- Supplier ☐
- Engineering ☐
- Quality ☐
- Other ☐

Root Cause		Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design	☐									
Doc/Data	☐									
Equip/Tooling	☐									
Handling/Pre	☐									
Material	☐									
Operator	☐									
Offset/Setup	☐									
Process	☐									
Supplier	☐									
Training	☐									
Transport	☐									
Unapproved	☐									

FAULT CATEGORY

Landing Gear

- ☐ Bending
- ☐ Centre Not Concentric
- ☐ Cracks
- ☐ Crimp/Kink/Ripple/Wave
- ☐ Cuffs
- ☐ Crushing
- ☐ Heat Treat
- ☐ Inspection Strip in Tube
- ☐ Marks/Chatter
- ☐ Turning Sequence
- ☐ Wave/Twist in Tube

General

- ☐ Bend
- ☐ BOM/Route
- ☐ Broken/Damage/Defect
- ☐ Burrs
- ☐ Contamination
- ☐ Countersink
- ☐ Cut Too Short
- ☐ Drawing
- ☐ Drill Holes
- ☐ Finish
- ☐ Fit/Function
- ☐ Folio/Program
- ☐ Grain
- ☐ Hardware
- ☐ Inspection Incomplete/Unqualified
- ☐ Instructions Incomplete/Unclear
- ☐ Misaligned/off center
- ☐ Mislabeled
- ☐ Misread
- ☐ Off-set
- ☐ Out of Calibration
- ☐ Out of Sequence
- ☐ Outside Dimensions
- ☐ Over/Under tolerance
- ☐ Part Incorrect
- ☐ Part Lost/Missing
- ☐ Part Moved
- ☐ Positioned Wrong
- ☐ Power Loss/Surge
- ☐ Pressure/Forced
- ☐ Set-up
- ☐ Temperature/Cure
- ☐ Weld
- ☐ Wrong Stock Pulled
- ☐ Other

_____

_____

_____

Picklist Print

August-06-14 9:02:13 AM

Work Order ID: 123262 *123262*

Parent Item: D350-636-012 *D350-636-012*

Parent Item Name: Skidtube RH Aerazur / Apical Cylindrical Compat.

Start Date: 8/07/14 **Required Date:** 8/14/14

Start Qty: 1.00 **Required Qty:** 1.00

AN8C35A	Purchased	No	230	Each	39.0000	1	1	
AN8C35A						**		ll 14/09/02
Bolt								

Location	Loc Qty	Loc Code	
FG	4	A11130114	
121275	4		X1
FP001	35		
m126293	29		
m127823	6		

MS21083C8	Purchased	No	230	Each	114.0000	1	1	
MS21083C8						**		ll 14/09/02
Nut								

Location	Loc Qty	Loc Code	
ST302	114		
m127255	5		
m128119	3		
m128798	106		X1

D2745	Manufactured	No	230	Each	163.0000	8	8	
D2745						**		ll 14/09/02
Bushing								

Location	Loc Qty	Loc Code	
ST010	163		
107336	4		
113176	2		
117099	36		
119572	113		X8
90323	2		
93336	6		

DART AEROSPACE

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date:

Work Order update only ☐

	DISPOSITION	AGAINST DEPARTMENT/PROCESS			
Work Order: _____	Rework ☐	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐
Part No. _____	Scrap ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coor. ☐	Quality ☐
	Use-as-is ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐
NCR No. _____	Suspected Unapproved ☐	Large Fab ☐	Composite ☐	Supplier ☐	

Root Cause		Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design	☐									
Doc/Data	☐									
Equip/Tooling	☐									
Handling/Pre	☐									
Material	☐									
Operator	☐									
Offset/Setup	☐									
Process	☐									
Supplier	☐									
Training	☐									
Transport	☐									
Unapproved	☐									

FAULT CATEGORY

Landing Gear		General				
☐ Bending	☐ Bend	☐ Folio/Program	☐ Outside Dimensions	☐ Pressure/Forced
☐ Centre Not Concentric	☐ BOM/Route	☐ Grain	☐ Over/Under tolerance	☐ Set-up
☐ Cracks	☐ Broken/Damage/Defect	☐ Hardware	☐ Part Incorrect	☐ Temperature/Cure
☐ Crimp/Kink/Ripple/Wave	☐ Burrs	☐ Inspection Incomplete/Unqualified	☐ Part Lost/Missing	☐ Weld
☐ Cuffs	☐ Contamination	☐ Instructions Incomplete/Unclear	☐ Part Moved	☐ Wrong Stock Pulled
☐ Crushing	☐ Countersink	☐ Misaligned/off center	☐ Positioned Wrong	
☐ Heat Treat	☐ Cut Too Short	☐ Mislabeled	☐ Power Loss/Surge	☐ Other
☐ Inspection Strip in Tube	☐ Drawing	☐ Misread		
☐ Marks/Chatter	☐ Drill Holes	☐ Off-set		
☐ Turning Sequence	☐ Finish	☐ Out of Calibration		
☐ Wave/Twist in Tube	☐ Fit/Function	☐ Out of Sequence		

Picklist Print

August-06-14 9:02:13 AM

Work Order ID: 123262 *123262*

Parent Item: D350-636-012 *D350-636-012*

Parent Item Name: Skidtube RH Aerazur / Apical Cylindrical Compat.

Start Date: 8/07/14 **Required Date:** 8/14/14

Start Qty: 1.00 **Required Qty:** 1.00

AN6C44A	Purchased	No	230	Each	111.0000	4	4		
AN6C44A						**			
Bolt									

Location	Loc Qty	Loc Code
FG	2	
103964	2	
ST333	109	
m128319	8	
m128700	1	
m129199	50	
m129505	50	

D3532-1	Manufactured	No	250	Each	23.0000	2	2		
D3532-1						**			
Spacer									

Location	Loc Qty	Loc Code
ST048	23	
115855	7	
117198	16	

MS21083C8	Purchased	No	250	Each	114.0000	2	2		
MS21083C8						**			
Nut									

Location	Loc Qty	Loc Code
ST302	114	
m127255	5	
m128119	3	
m128798	106	

DART AEROSPACE

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date:

Work Order update only ☐

Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION

- Rework ☐
- Scrap ☐
- Use-as-is ☐
- Suspected Unapproved ☐

AGAINST DEPARTMENT/PROCESS

- Skid-tube ☐
- Machining ☐
- Thermoforming ☐
- Large Fab ☐
- Crosstube ☐
- Small Fab ☐
- Finishing ☐
- Composite ☐
- Water Jet ☐
- Prod. Eng. Coor. ☐
- Rec/Store/Packaging ☐
- Supplier ☐
- Engineering ☐
- Quality ☐
- Other ☐

Root Cause		Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design	☐									
Doc/Data	☐									
Equip/Tooling	☐									
Handling/Pre	☐									
Material	☐									
Operator	☐									
Offset/Setup	☐									
Process	☐									
Supplier	☐									
Training	☐									
Transport	☐									
Unapproved	☐									

FAULT CATEGORY

Landing Gear

- ☐ Bending
- ☐ Centre Not Concentric
- ☐ Cracks
- ☐ Crimp/Kink/Ripple/Wave
- ☐ Cuffs
- ☐ Crushing
- ☐ Heat Treat
- ☐ Inspection Strip in Tube
- ☐ Marks/Chatter
- ☐ Turning Sequence
- ☐ Wave/Twist in Tube

General

- ☐ Bend
- ☐ BOM/Route
- ☐ Broken/Damage/Defect
- ☐ Burrs
- ☐ Contamination
- ☐ Countersink
- ☐ Cut Too Short
- ☐ Drawing
- ☐ Drill Holes
- ☐ Finish
- ☐ Fit/Function
- ☐ Folio/Program
- ☐ Grain
- ☐ Hardware
- ☐ Inspection Incomplete/Unqualified
- ☐ Instructions Incomplete/Unclear
- ☐ Misaligned/off center
- ☐ Mislabeled
- ☐ Misread
- ☐ Off-set
- ☐ Out of Calibration
- ☐ Out of Sequence
- ☐ Outside Dimensions
- ☐ Over/Under tolerance
- ☐ Part Incorrect
- ☐ Part Lost/Missing
- ☐ Part Moved
- ☐ Positioned Wrong
- ☐ Power Loss/Surge
- ☐ Pressure/Forced
- ☐ Set-up
- ☐ Temperature/Cure
- ☐ Weld
- ☐ Wrong Stock Pulled
- ☐ Other

_____

_____

_____

Picklist Print

August-06-14 9:02:13 AM

Work Order ID: 123262 *123262*

Parent Item: D350-636-012 *D350-636-012*

Parent Item Name: Skidtube RH Aerazur / Apical Cylindrical Compat.

Start Date: 8/07/14 **Required Date:** 8/14/14

Start Qty: 1.00 **Required Qty:** 1.00

NAS1149D0863J Purchased No 250 Each 829.0000 2 2 DAS 32 9-89

NAS1149D0863J

Washer

**

Location		Loc Qty	Loc Code
ST276		629	
	118078	2	
	125268	600	
	125484	27	
ST2776		200	
	125635	200	

DAS 06 9-89

2 M125268

D3493-1 Manufactured No 250 Each 171.0000 2 2 DAS 32 9-89

D3493-1

Washer

**

Location		Loc Qty	Loc Code
FG		10	
	97201	10	
ST046		161	
	109105	155	
	112741	4	
	97201	2	

DAS 06 9-89

2 B109105

ONLY INSTALL IF INSTALLING ON APICAL FLOAT SYSTEM

AN8C21A Purchased No 250 Each 106.0000 2 2 DAS 32 9-89 14/9/4 (1)

AN8C21A

Bolt

**

Location		Loc Qty	Loc Code
FG		2	
	123966	2	
ST332		104	
	m127061	2	
	m127823	15	
	m129888	87	

DAS 06 9-89

2 M128888

DART AEROSPACE

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date:

Work Order update only ☐

Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION

- Rework ☐
- Scrap ☐
- Use-as-is ☐
- Suspected Unapproved ☐

AGAINST DEPARTMENT/PROCESS

- Skid-tube ☐
- Machining ☐
- Thermoforming ☐
- Large Fab ☐
- Crosstube ☐
- Small Fab ☐
- Finishing ☐
- Composite ☐
- Water Jet ☐
- Prod. Eng. Coor. ☐
- Rec/Store/Packaging ☐
- Supplier ☐
- Engineering ☐
- Quality ☐
- Other ☐

Root Cause		Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design	☐									
Doc/Data	☐									
Equip/Tooling	☐									
Handling/Pre	☐									
Material	☐									
Operator	☐									
Offset/Setup	☐									
Process	☐									
Supplier	☐									
Training	☐									
Transport	☐									
Unapproved	☐									

FAULT CATEGORY

Landing Gear

- ☐ Bending
- ☐ Centre Not Concentric
- ☐ Cracks
- ☐ Crimp/Kink/Ripple/Wave
- ☐ Cuffs
- ☐ Crushing
- ☐ Heat Treat
- ☐ Inspection Strip in Tube
- ☐ Marks/Chatter
- ☐ Turning Sequence
- ☐ Wave/Twist in Tube

General

- ☐ Bend
- ☐ BOM/Route
- ☐ Broken/Damage/Defect
- ☐ Burrs
- ☐ Contamination
- ☐ Countersink
- ☐ Cut Too Short
- ☐ Drawing
- ☐ Drill Holes
- ☐ Finish
- ☐ Fit/Function
- ☐ Folio/Program
- ☐ Grain
- ☐ Hardware
- ☐ Inspection Incomplete/Unqualified
- ☐ Instructions Incomplete/Unclear
- ☐ Misaligned/off center
- ☐ Mislabeled
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- ☐ Over/Under tolerance
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- ☐ Part Moved
- ☐ Positioned Wrong
- ☐ Power Loss/Surge
- ☐ Pressure/Forced
- ☐ Set-up
- ☐ Temperature/Cure
- ☐ Weld
- ☐ Wrong Stock Pulled
- ☐ Other

_____

_____

_____

QTY -041	QTY -042	QTY -043	QTY -044	PART NUMBER	DESCRIPTION
X				D2750-041	350 SKIDTUBE ASSEMBLY, LH
	X			D2750-042	350 SKIDTUBE ASSEMBLY, RH
		X		D2750-043	350 SKIDTUBE ASSEMBLY, LH
			X	D2750-044	350 SKIDTUBE ASSEMBLY, RH
1	1	1	1	D2739	WEB
8	8	8	8	D2743	SPACER
1	1	1	1	D2744	CAP
8	8	8	8	D2745	BUSHING
1				D2750-1	SKIDTUBE WELDMENT, LH
	1			D2750-2	SKIDTUBE WELDMENT, RH
		1		D2750-3	SKIDTUBE WELDMENT, LH
			1	D2750-4	SKIDTUBE WELDMENT, RH
1		1		D3488-041	BLADE FITTING, LH
	1		1	D3488-042	BLADE FITTING, RH
4	4	4	4	D3490-1	SPACER
4	4			D3490-3	SPACER
		4	4	D3490-5	SPACER
8	8	8	8	D3492-041	PLUG ASSEMBLY
8	8			D3492-043	PLUG ASSEMBLY
		8	8	D3492-045	PLUG ASSEMBLY
1	1	1	1	D3535-25	WEARSHOE
1	1	1	1	D3536-25	GASKET
3	3	3	3	D3537-1	WEARPAD
8	8	8	8	D3631-1	WASHER
1	1	1	1	D3791-1	WEARPLATE
1	1	1	1	D3793-1	WEARSHOE
1	1	1	1	D3793-3	WEARSHOE
1	1	1	1	D3794-1	GASKET
1	1	1	1	D3794-3	GASKET
38	38	38	38	ALS4-1032-225	INSERT (OR ALS7-1032-225, AKS4-1032-225, AELS-1032-225)
34	34	34	34	AN3C5A	BOLT
4	4	4	4	AN3C6A	BOLT
4	4	4	4	AN6C44A	BOLT
1	1	1	1	AN8C35A	BOLT
38	38	38	38	AN960C10L	WASHER
1	1	1	1	AN960C816L	WASHER
4	4	4	4	MS21043-6	NUT
1	1	1	1	MS21083C8	NUT
4	4	4	4	NAS1515H3L	WASHER

SHOP COPY
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ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 1232162
08/06/14 wm

RELEASED
2013 -08- 13

GENERAL NOTES:

1) MATERIAL: MAKE D2750-1/-2/-3/-4 FROM D2600-3 EXTRUSION (INITIAL LENGTH = 120.0).
2) FINISH: ACID ETCH, ALODINE ASSEMBLY PER DART QSI 005 4.1 PRIOR TO INSTALLING D2739 WEB.
   STANDARD: PRIME (REF. 4.2.1.3.3) AND PAINT WHITE PER DART QSI 005 4.2
   △G OPTIONAL: POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3
   BLACK ANTI-SKID PAINT AS INDICATED TO 1.0 ABOVE SKIDTUBE CENTER-LINE PER DART 005 4.4 (OPTIONAL).
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: N/A
6) IDENTIFICATION: N/A
7) WEIGHT: D2750-041/-042/-043/-044 = 26.5 LBS
8) WELD PER DART QSI 004
9) INSTALL ALS4-1032-225 INSERTS AFTER FINISH AS INDICATED. DRILL 'F' SIZE HOLES (Ø0.297) FOR WEARSHOE INSERTS
10) FINAL CONFIGURATION SHOULD HAVE THE FOLLOWING MINIMUM MECHANICAL PROPERTIES:
    MINIMUM YIELD TENSILE STRENGTH = 35 KSI
    MINIMUM ULTIMATE TENSILE STRENGTH = 38 KSI
11) COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF FINISH WITH MEK DEGREASER.
12) SPACER AND PLUG INSTALLED SAME AS SECTION AJ-AJ EXCEPT HORIZONTAL
13) SPACER AND PLUG INSTALLED SAME AS SECTION AP-AP EXCEPT HORIZONTAL

REV.	DESCRIPTION	BY	DATE
G	CORRECTED TOLERANCE ON Ø0.500 THRU HOLE: IS +0.010/-0.000, WAS +0.100/-0.000 (ZN B3-4, B2-5); ADD VIEW TO CONTROL FWD BEND ORIENTATION (ZN D-1-4/-5/-6/-7); UPDATED FINISH OPTIONS; INSIDE OF TUBE NO LONGER SPRAYED WITH LPS-3. REASON: PAR13-276 AND NCR13-2757	MB	13.07.11
F	INCORPORATE DSI 9413. QTY (3) D3537-1 WAS QTY (5) (ZN C8-1); D3791-1/-3 REPLACES D3535-13/-35 (ZN C8-1); D3794-1/-3 REPLACES D3536-13/-35 (ZN B8-1); ADD D3791-1 (ZN C8-1); WEARSHOE HOLES UNDER FWD/AFT SADDLE REMOVED (8 PL). WEARSHOE HARDWARE QTY UPDATED (ZN B8-1); D3488-041/-042 HARDWARE UPDATED (ZN C1-8, 9, 10, 11); ADD NOTE 12 AND 13 (ZN A6-1); REASON: REF. NCR 08-043	PH	08.07.16
E	CHANGE TO STAINLESS STEEL WEARPLATES; ADD RUBBER GASKETS; CHANGE INSERTS; ADD D3631-1; REMOVE QTY (38) NAS1515H3L; REMOVE QTY (10) NAS1515H8L; REMOVE D2741, QTY (2) AN960C816; REMOVE QTY (2) MS21083C8	CB	07.05.17
D	ADD HOLES AND SPACERS FOR APICAL FLOATS; INCORPORATE DEO 9133/9157	PH	06.01.05
C	ADD D2750-3/D2750-4; INCORPORATE D2738 AND D2740	CP	98.11.18
B	CHANGE MS24694-S293 TO AN8-16A	CP	98.09.01
A	NEW ISSUE	DS	98.04.16

DESIGN	MM	**DART AEROSPACE USA, INC.** KENT, WA
DRAWN		
CHECKED		DRAWING NO. D2750 — REV. G — SHEET 1 OF 11
MFG. APPR.		
APPROVED		TITLE: 350 SKIDTUBE ASSEMBLY — SCALE: NTS
DE APPR.		
DATE	13.07.11	

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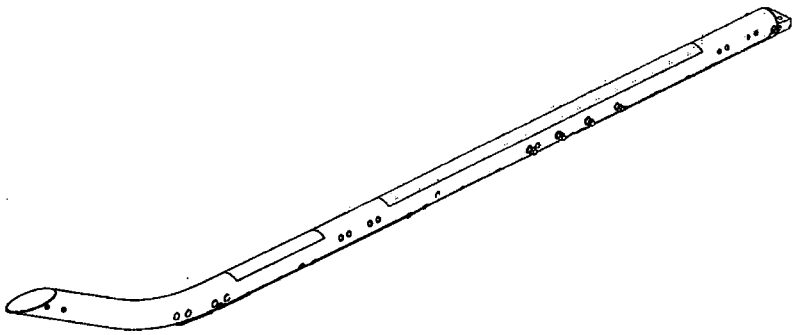
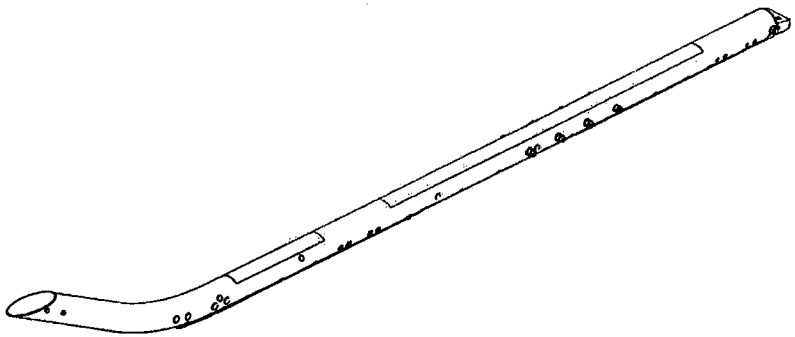


D2750-041 350 SKIDTUBE ASSEMBLY, LH



D2750-042 350 SKIDTUBE ASSEMBLY, RH

RELEASED
2013 -08- 13

DESIGN	MM	**DART AEROSPACE USA, INC.** KENT, WA
DRAWN		
CHECKED		DRAWING NO. D2750 — REV. G — SHEET 2 OF 11
MFG. APPR.		
APPROVED		TITLE: 350 SKIDTUBE ASSEMBLY — SCALE: NTS
DE APPR.		
DATE	13.07.11	

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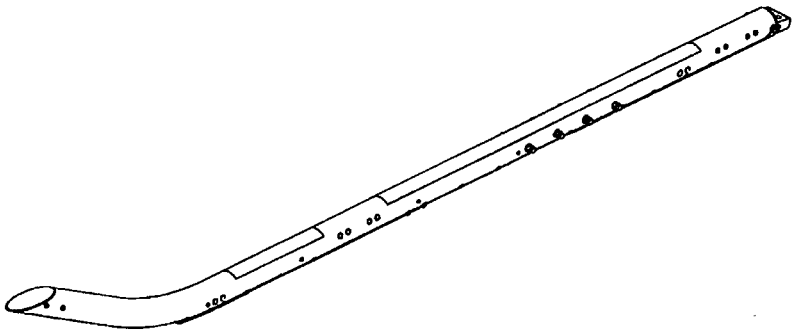
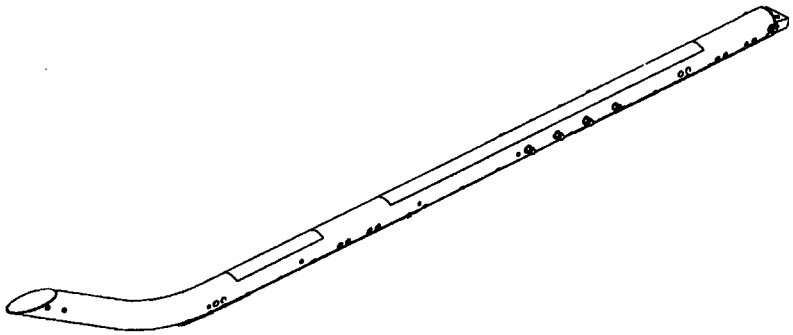


D2750-043 350 SKIDTUBE ASSEMBLY, LH



D2750-044 350 SKIDTUBE ASSEMBLY, RH

RELEASED
2013 -08- 13

DESIGN	MM	DART AEROSPACE USA, INC. KENT, WA
DRAWN		
CHECKED		DRAWING NO. D2750 — REV. G — SHEET 3 OF 11
MFG. APPR.		
APPROVED		TITLE 350 SKIDTUBE ASSEMBLY — SCALE NTS
DE APPR.		
DATE 13.07.11		

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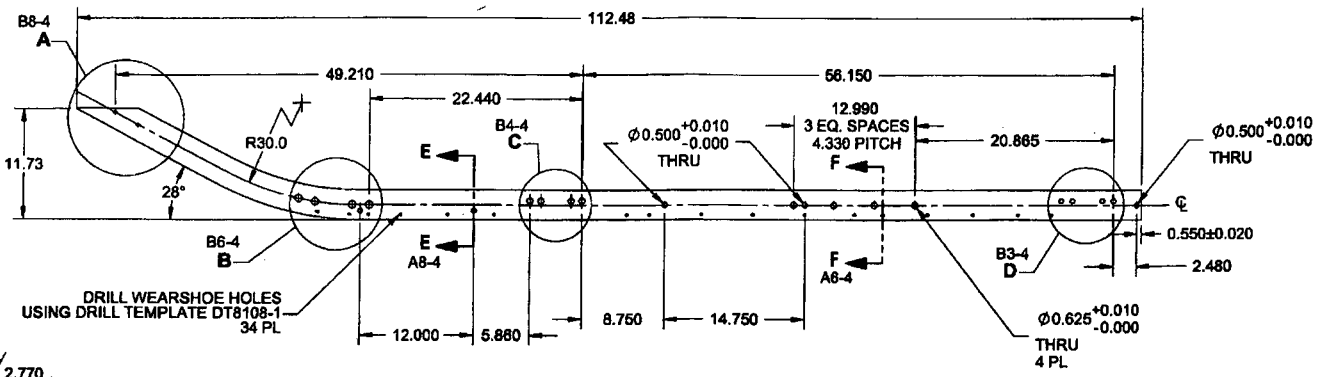
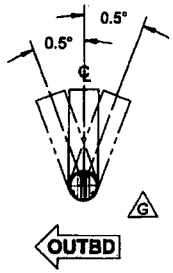
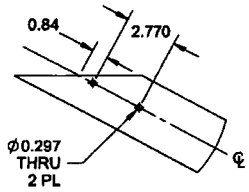


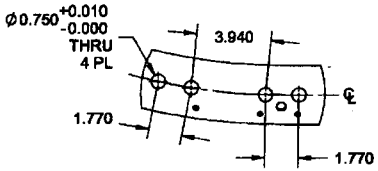
D2750-1 LH SKIDTUBE



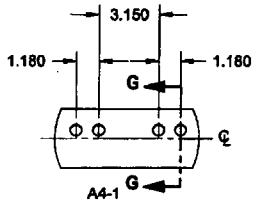
MAX ALLOWABLE
TWIST ON FWD BEND
(VIEWED LOOKING FWD)



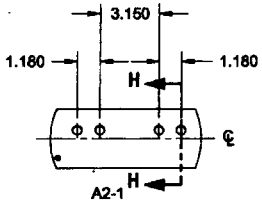
DETAIL A D7-4
SCALE 2X



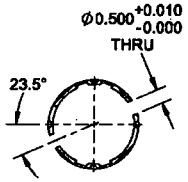
DETAIL B D7-4
SCALE 2X



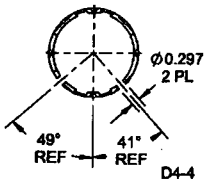
DETAIL C D5-4
SCALE 2X



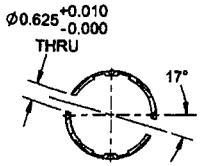
DETAIL D D3-4
SCALE 2X



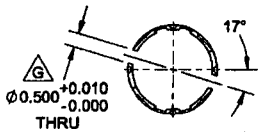
SECTION E-E D6-4
SCALE 3X, 2 PL



SECTION F-F D4-4
SCALE 3X, 17 PL



SECTION G-G B4-4
SCALE 3X, 4 PL



SECTION H-H B2-4
SCALE 3X, 4 PL

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2013 -08- 13

DESIGN	MM	DART AEROSPACE USA, INC. KENT, WA
DRAWN		
CHECKED		DRAWING NO. D2750 — REV. G — SHEET 4 OF 11
MFG. APPR.		
APPROVED		TITLE: 350 SKIDTUBE ASSEMBLY — SCALE: NTS
DE APPR.		
DATE	13.07.11	

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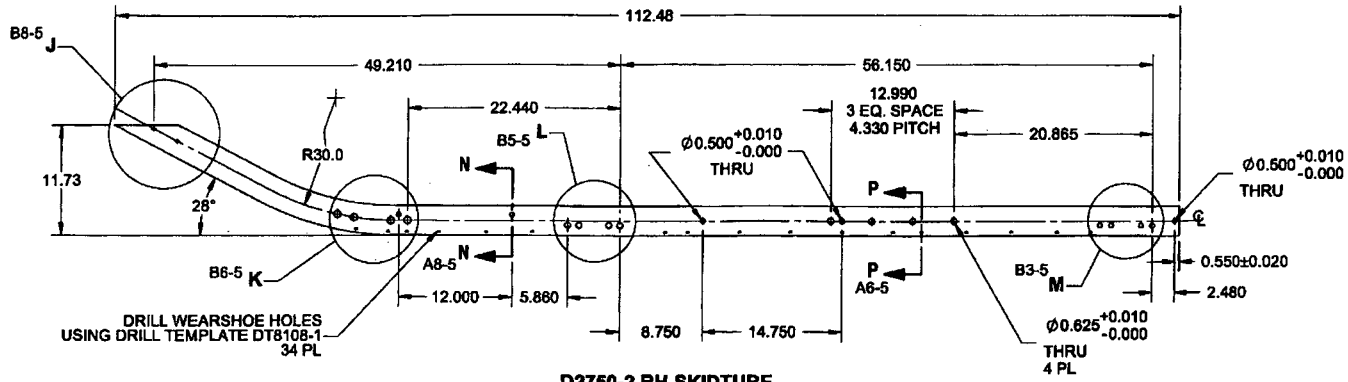
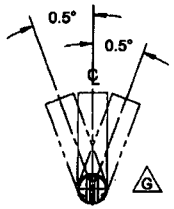
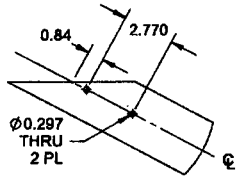


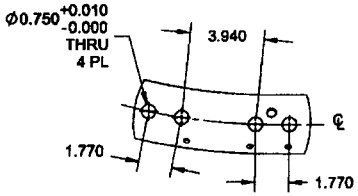
D2750-2 RH SKIDTUBE



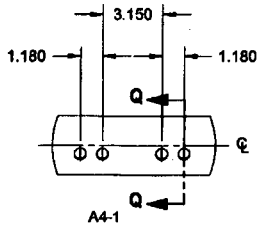
MAX ALLOWABLE TWIST ON FWD BEND (VIEWED LOOKING FWD)



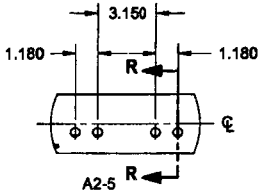
DETAIL J D8-5
SCALE 2X



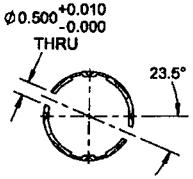
DETAIL K C7-5
SCALE 2X



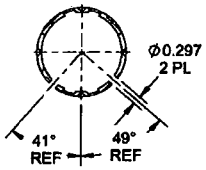
DETAIL L D6-5
SCALE 2X



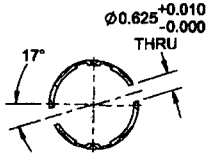
DETAIL M C3-5
SCALE 2X



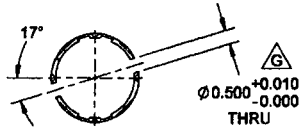
SECTION N-N C6-5
SCALE 3X, 2 PL



SECTION P-P C4-5
SCALE 3X, 17 PL



SECTION Q-Q B5-5
SCALE 3X, 4 PL



SECTION R-R B3-5
SCALE 3X, 4 PL

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2013-08-13

DESIGN	MM	DART AEROSPACE USA, INC. KENT, WA
DRAWN		
CHECKED		DRAWING NO. D2750 — REV. G — SHEET 5 OF 11
MFG. APPR.		
APPROVED		TITLE: 350 SKIDTUBE ASSEMBLY — SCALE: NTS
DE APPR.		
DATE	13.07.11	

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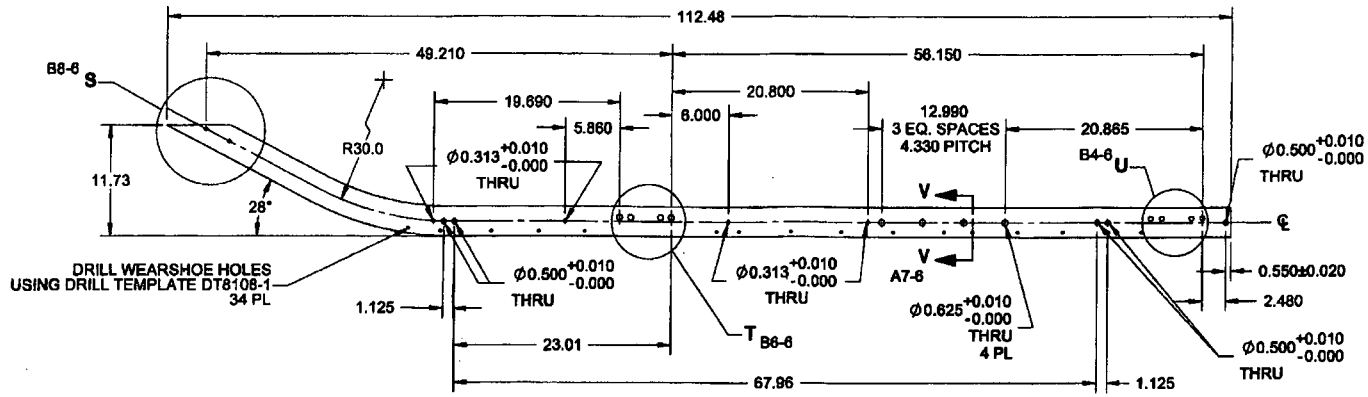
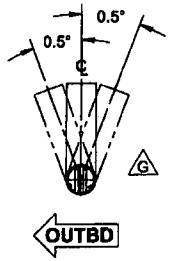
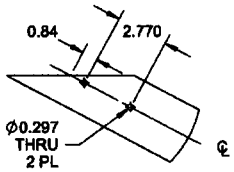


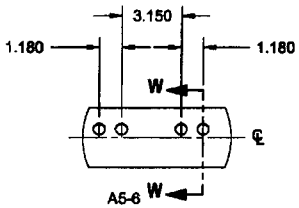
D2750-3 LH SKIDTUBE



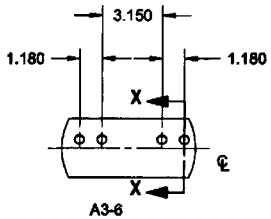
MAX ALLOWABLE
TWIST ON FWD BEND
(VIEWED LOOKING FWD)



DETAIL S D8-6
SCALE 2X



DETAIL T C5-6
SCALE 2X



DETAIL U D3-6
SCALE 2X

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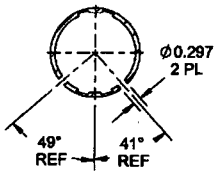
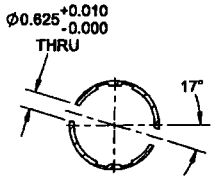
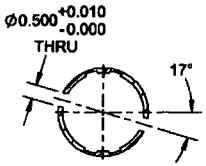
2013 -08- 13



SECTION V-V C4-6
SCALE 3X, 17 PL



SECTION W-W B6-6
SCALE 3X, 4 PL



SECTION X-X B4-6
SCALE 3X, 4 PL

DESIGN	MM	**DART AEROSPACE USA, INC.** KENT, WA
DRAWN		DRAWING NO. D2750 — REV. G — SHEET 6 OF 11
CHECKED		
MFG. APPR.		
APPROVED		TITLE: 350 SKIDTUBE ASSEMBLY — SCALE: NTS
DE APPR.		
DATE	13.07.11	

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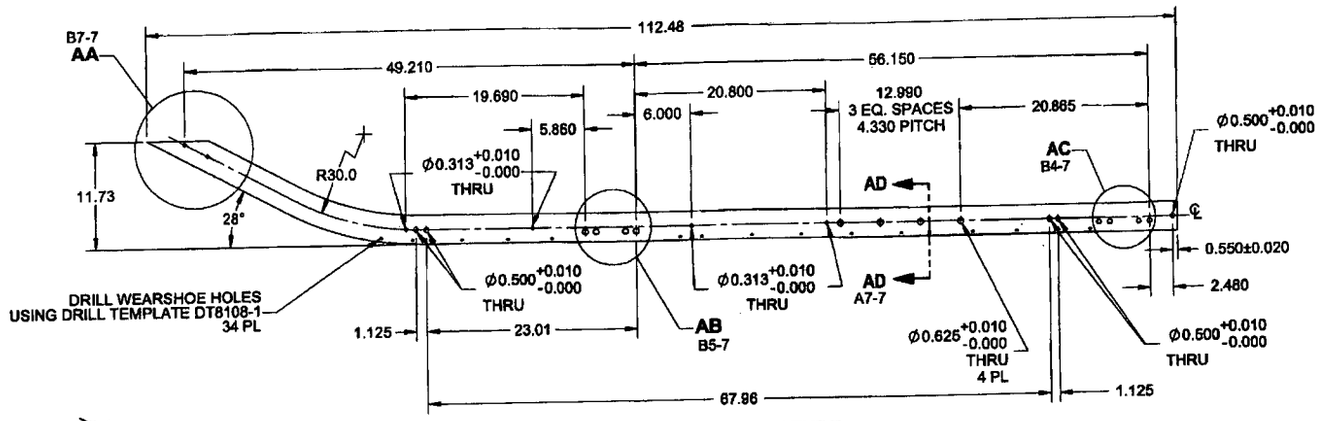
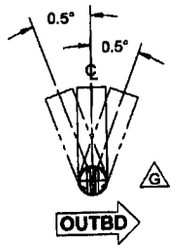
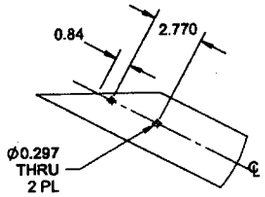


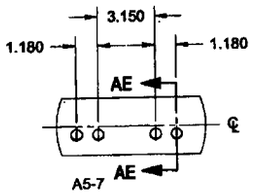
D2750-4 RH SKIDTUBE



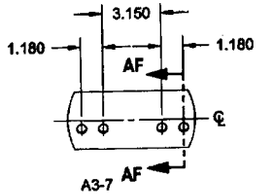
MAX ALLOWABLE
TWIST ON FWD BEND
(VIEWED LOOKING FWD)



DETAIL AA D7-7
SCALE 2X



DETAIL AB C4-7
SCALE 2X



DETAIL AC D3-7
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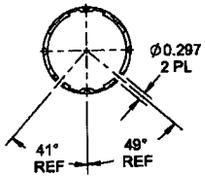
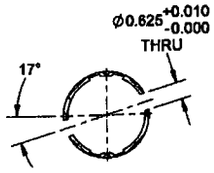
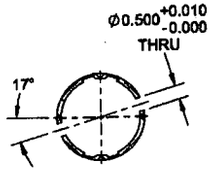


SECTION AD-AD D3-7
SCALE 3X, 17 PL



SECTION AE-AE B6-7
SCALE 3X, 4 PL



SECTION AF-AF B4-7
SCALE 3X, 4 PL

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2013 -08- 13

DESIGN	MM	DART AEROSPACE USA, INC. KENT, WA
DRAWN		DRAWING NO. D2750 — REV. G — SHEET 7 OF 11
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MFG. APPR.		
APPROVED		TITLE 350 SKIDTUBE ASSEMBLY — SCALE NTS
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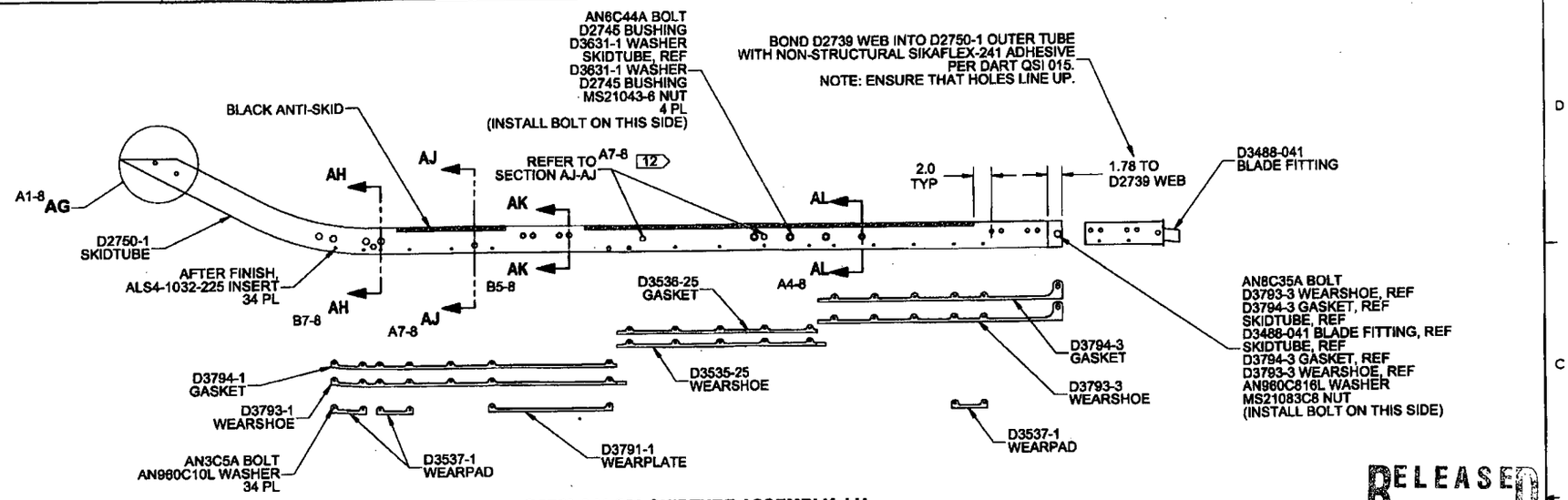
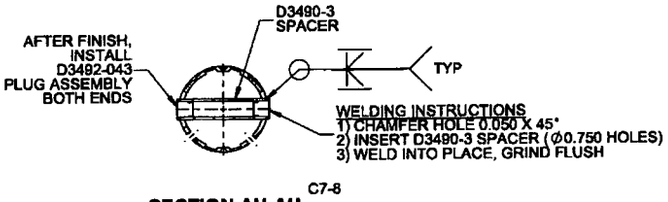


D2750-041 350 SKIDTUBE ASSEMBLY, LH

RELEASED
2013 -08- 13



SECTION AH-AH
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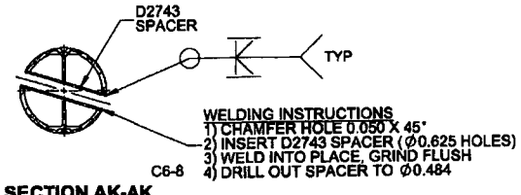

SECTION AK-AK
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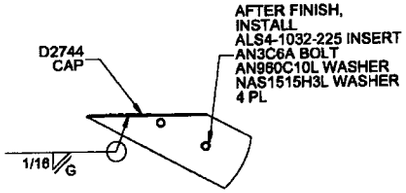
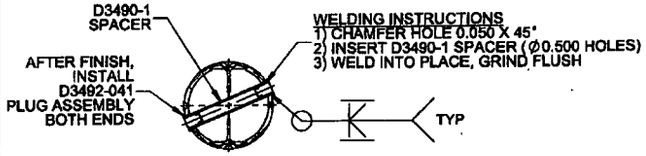
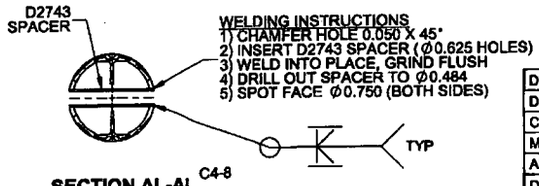


DETAIL AG D8-8
SCALE 2X



SECTION AJ-AJ
SCALE 3X, 4 PL



SECTION AL-AL
SCALE 3X, 4 PL
(HARDWARE REMOVED FOR CLARITY)

DESIGN	MM	DART AEROSPACE USA, INC. KENT, WA
DRAWN		DRAWING NO. D2750 — REV. G — SHEET 8 OF 11
CHECKED		
MFG. APPR.		
APPROVED		TITLE: 350 SKIDTUBE ASSEMBLY — SCALE: NTS
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DATE	13.07.11	

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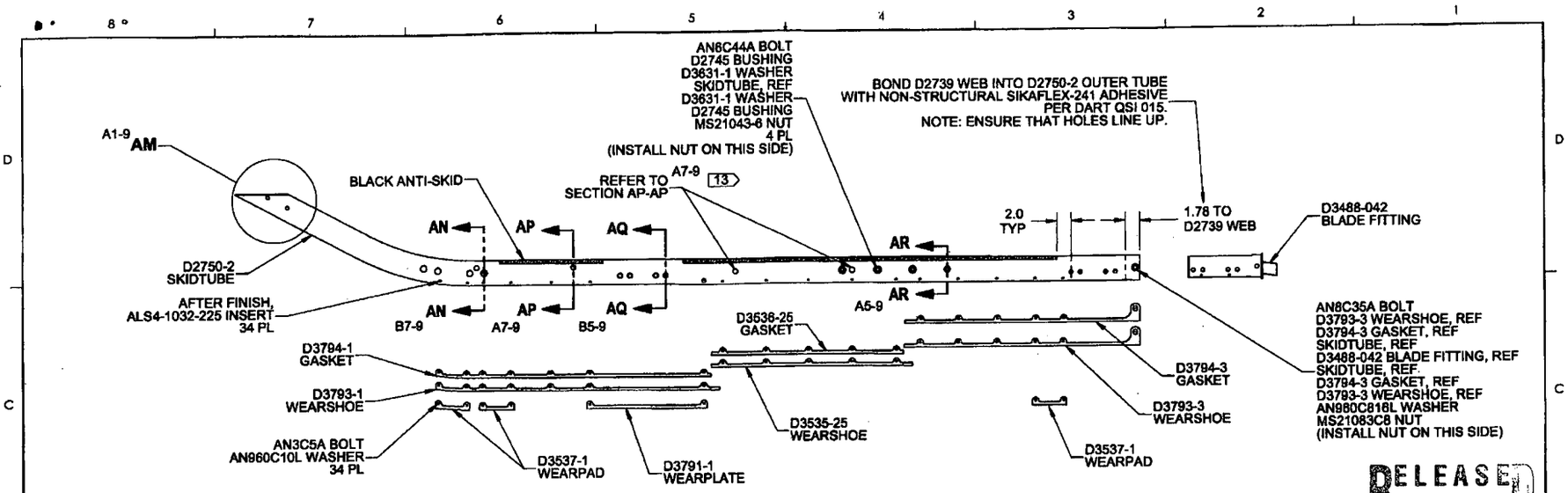

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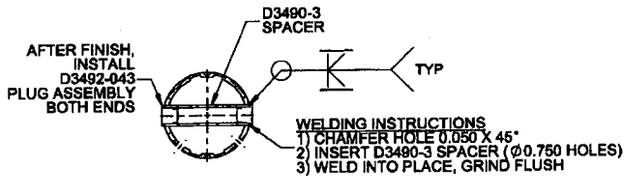
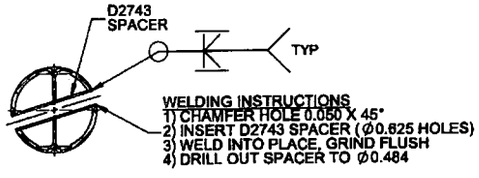
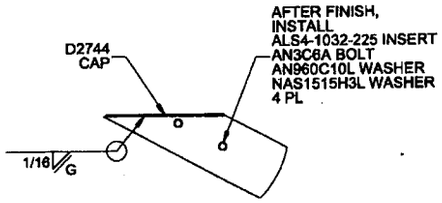
D2750-042 350 SKIDTUBE ASSEMBLY, RH



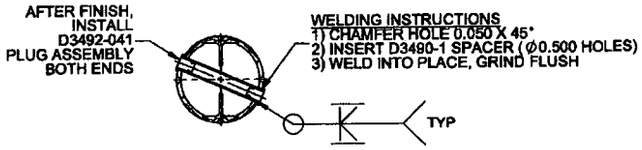
SECTION AN-AN C7-9
SCALE 3X, 4 PL



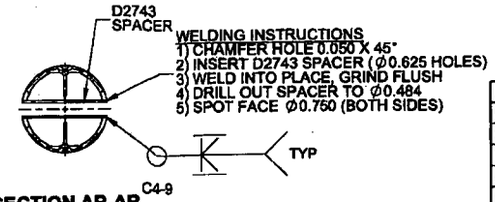
SECTION AQ-AQ C5-9
SCALE 3X, 4 PL



DETAIL AM D8-9
SCALE 2X



SECTION AP-AP C6-9, D5-9
SCALE 3X, 4 PL



SECTION AR-AR C4-9
SCALE 3X, 4 PL
(HARDWARE REMOVED FOR CLARITY)

DESIGN	NM	**DART AEROSPACE USA, INC.** KENT, WA
DRAWN		DRAWING NO. D2750 — REV. G — SHEET 9 OF 11
CHECKED		
MFG. APPR.		
APPROVED		TITLE: 350 SKIDTUBE ASSEMBLY — SCALE: NTS
DE APPR.		
DATE	13.07.11	

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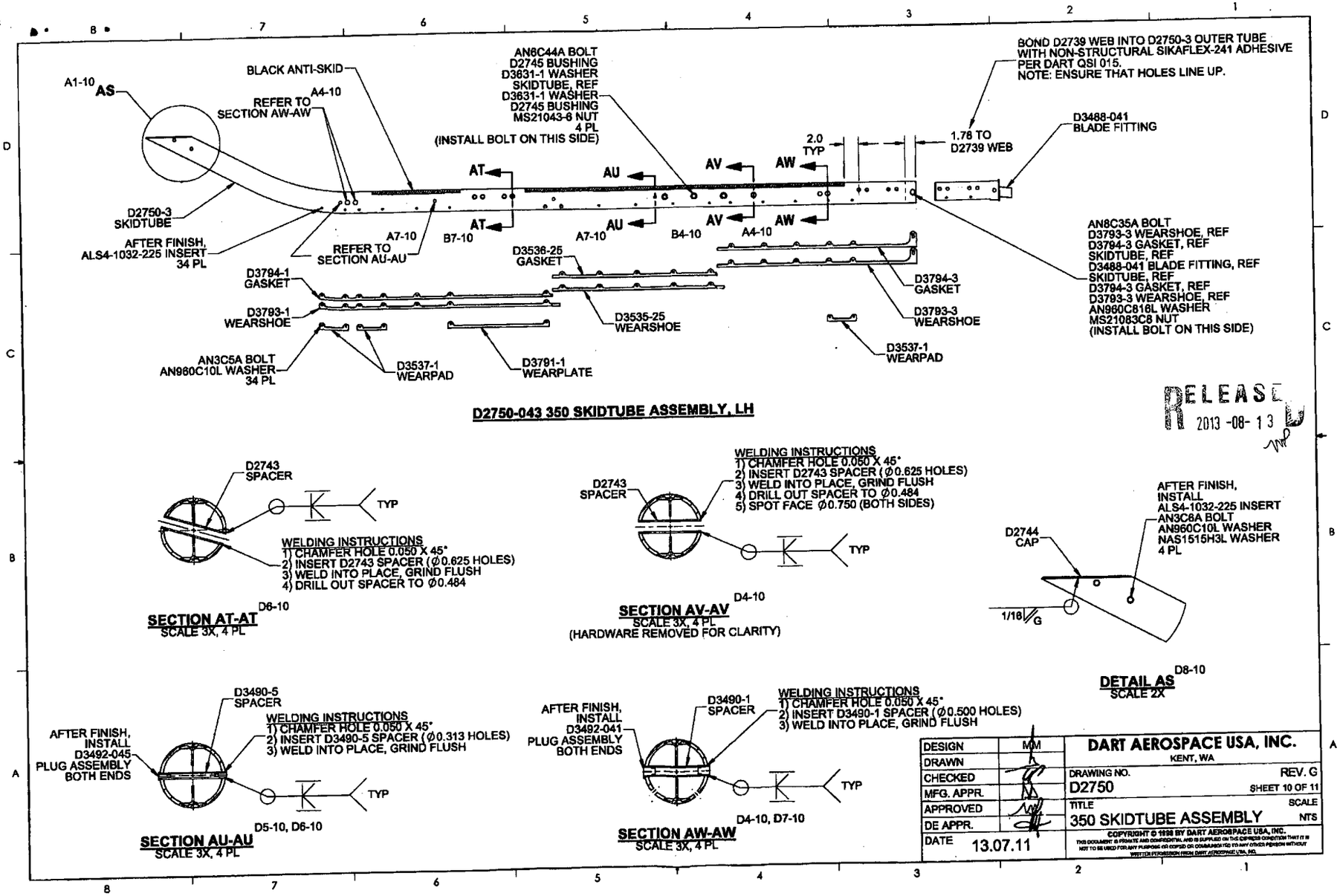
A1-10
AS
BLACK ANTI-SKID
A4-10
REFER TO SECTION AW-AW
AN6C44A BOLT
D2745 BUSHING
D3631-1 WASHER
SKIDTUBE, REF
D3631-1 WASHER
D2745 BUSHING
MS21043-6 NUT
4 PL
(INSTALL BOLT ON THIS SIDE)
BOND D2739 WEB INTO D2750-3 OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241 ADHESIVE PER DART QSI 015.
NOTE: ENSURE THAT HOLES LINE UP.
D3488-041 BLADE FITTING
2.0 TYP
1.78 TO D2739 WEB
AT
AU
AV
AW
D2750-3 SKIDTUBE
AFTER FINISH, ALS4-1032-225 INSERT 34 PL
A7-10
B7-10
REFER TO SECTION AU-AU
B4-10
A4-10
D3536-25 GASKET
D3794-1 GASKET
D3793-1 WEARSHOE
D3535-25 WEARSHOE
D3794-3 GASKET
D3793-3 WEARSHOE
AN8C35A BOLT
D3793-3 WEARSHOE, REF
D3794-3 GASKET, REF
SKIDTUBE, REF
D3488-041 BLADE FITTING, REF
SKIDTUBE, REF
D3794-3 GASKET, REF
D3793-3 WEARSHOE, REF
AN960C816L WASHER
MS21083C8 NUT
(INSTALL BOLT ON THIS SIDE)
AN3C5A BOLT
AN960C10L WASHER
34 PL
D3537-1 WEARPAD
D3791-1 WEARPLATE
D3537-1 WEARPAD
D2750-043 350 SKIDTUBE ASSEMBLY, LH
RELEASED
2013 -08- 13
D2743 SPACER
TYP
WELDING INSTRUCTIONS
1) CHAMFER HOLE 0.050 X 45°
2) INSERT D2743 SPACER (Ø0.625 HOLES)
3) WELD INTO PLACE, GRIND FLUSH
4) DRILL OUT SPACER TO Ø0.484
D6-10
SECTION AT-AT
SCALE 3X, 4 PL
WELDING INSTRUCTIONS
1) CHAMFER HOLE 0.050 X 45°
2) INSERT D2743 SPACER (Ø0.625 HOLES)
3) WELD INTO PLACE, GRIND FLUSH
4) DRILL OUT SPACER TO Ø0.484
5) SPOT FACE Ø0.750 (BOTH SIDES)
D2743 SPACER
TYP
D4-10
SECTION AV-AV
SCALE 3X, 4 PL
(HARDWARE REMOVED FOR CLARITY)
AFTER FINISH, INSTALL
ALS4-1032-225 INSERT
AN3C8A BOLT
AN960C10L WASHER
NAS1515H3L WASHER
4 PL
D2744 CAP
1/16 G
D8-10
DETAIL AS
SCALE 2X
D3490-5 SPACER
WELDING INSTRUCTIONS
1) CHAMFER HOLE 0.050 X 45°
2) INSERT D3490-5 SPACER (Ø0.313 HOLES)
3) WELD INTO PLACE, GRIND FLUSH
AFTER FINISH, INSTALL
D3492-045
PLUG ASSEMBLY
BOTH ENDS
TYP
D5-10, D6-10
SECTION AU-AU
SCALE 3X, 4 PL
AFTER FINISH, INSTALL
D3492-041
PLUG ASSEMBLY
BOTH ENDS
D3490-1 SPACER
WELDING INSTRUCTIONS
1) CHAMFER HOLE 0.050 X 45°
2) INSERT D3490-1 SPACER (Ø0.500 HOLES)
3) WELD INTO PLACE, GRIND FLUSH
TYP
D4-10, D7-10
SECTION AW-AW
SCALE 3X, 4 PL
DESIGN MM
DRAWN
CHECKED
MFG. APPR.
APPROVED
DE APPR.
DATE 13.07.11
DART AEROSPACE USA, INC.
KENT, WA
DRAWING NO. D2750
REV. G
SHEET 10 OF 11
TITLE 350 SKIDTUBE ASSEMBLY
SCALE NTS
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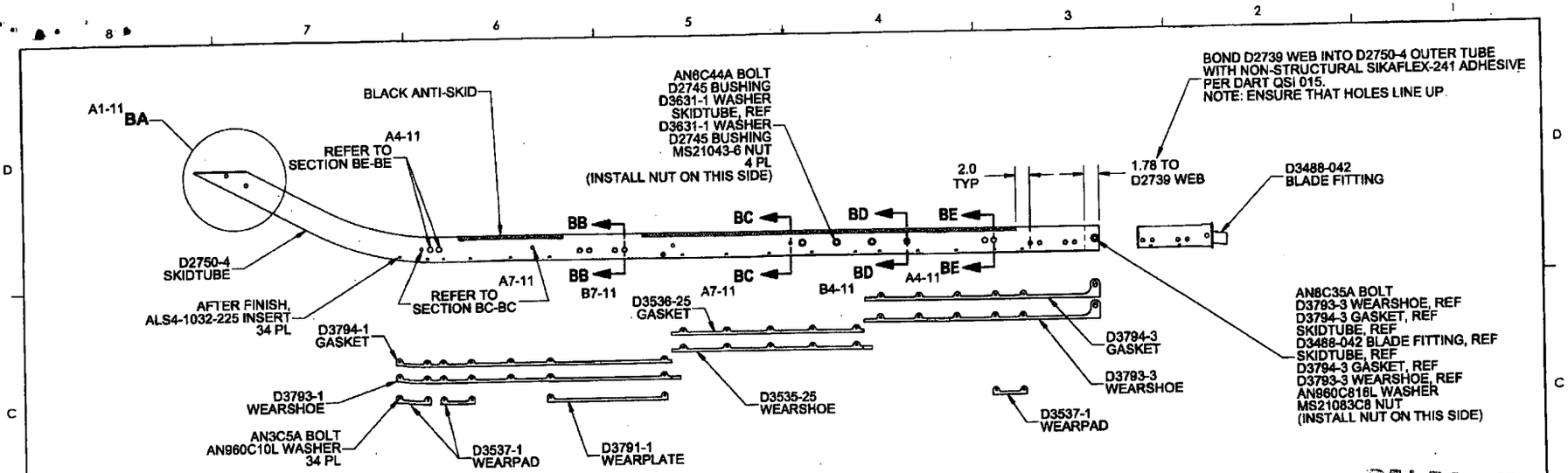
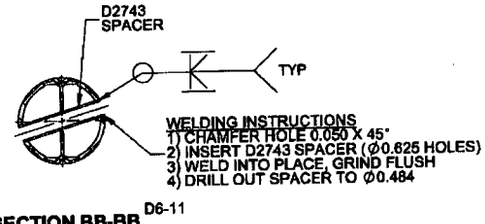
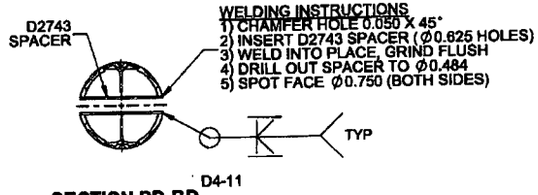


D2750-044 350 SKIDTUBE ASSEMBLY, RH

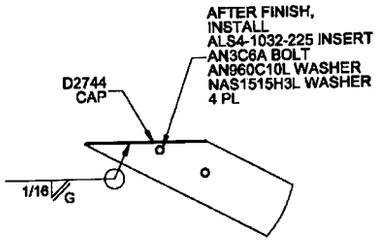
RELEASED
2013 -08- 13



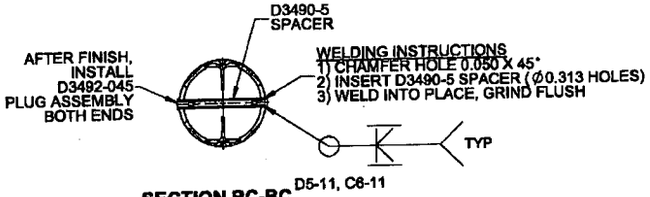
SECTION BB-BB
SCALE 3X, 4 PL



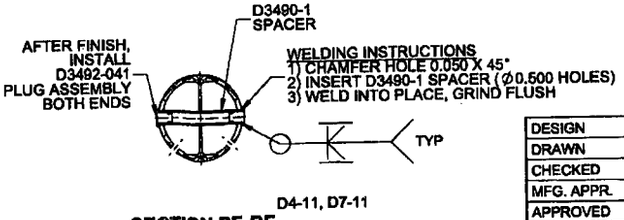
SECTION BD-BD
SCALE 3X, 4 PL
(HARDWARE REMOVED FOR CLARITY)



DETAIL BA
SCALE 2X



SECTION BC-BC
SCALE 3X, 4 PL



SECTION BE-BE
SCALE 3X, 4 PL

DESIGN	MM	DART AEROSPACE USA, INC. KENT, WA
DRAWN		DRAWING NO. D2750 — REV. G — SHEET 11 OF 11
CHECKED		
MFG. APPR.		
APPROVED		TITLE: 350 SKIDTUBE ASSEMBLY — SCALE: NTS
DE APPR.		
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PAR 14-338

Patrick Smith
May-29-14 1:29 PM
Linda Lacelle; Mike Petsche
Nigel Forbes; Eric Downing; Nancy MacLeod; David Shepherd
RE: 350 skids and 206 skids

avid and he would allow us to use a RTV product to bond the Plugs into the Skidtube.

ugs would require:
val from the Skidtube
val of the current O-Ring
ng with Alcohol
ation of NEW O-Ring
ous coating of the RTV
ion of plug into the Spacer
up of exterior of Skidtube.

Lacelle
)-14 10:21 AM
che
bes; Patrick Smith; Eric Downing; Nancy MacLeod
) skids and 206 skids
: High

rday that plugs were falling out. Today we were told that we cannot ship any 350 skids. We have an order to ship today, has there been a solution
... let the customer know if his order is shipping or not...